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**Danziger et al.**

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(54) **METHODS OF FABRICATION OF OPTICAL APERTURE MULTIPLIERS HAVING RECTANGULAR WAVEGUIDE**

(58) **Field of Classification Search**  
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(57) **ABSTRACT**

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A method of fabricating an optical aperture multiplier is provided. A slice and a first optical structure are obtained. The slice has external faces including a pair of parallel faces, and a first plurality of partially reflective internal surfaces oblique to the pair of parallel faces. The first optical structure has external surfaces including a planar coupling surface, and a second plurality of partially reflective internal surfaces oblique to the coupling surface. The slice is optically coupled with the first optical structure such that one of the faces of the pair of parallel faces is in facing relation with the coupling surface to form a second optical structure. At least one optical aperture multiplier is sliced from the second optical structure by cutting the second optical structure through at least two cutting planes perpendicular to the coupling surface. The optical aperture multiplier is preferably part of a near eye display augmented reality system.

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**Related U.S. Application Data**

(60) Provisional application No. 63/197,542, filed on Jun. 7, 2021.

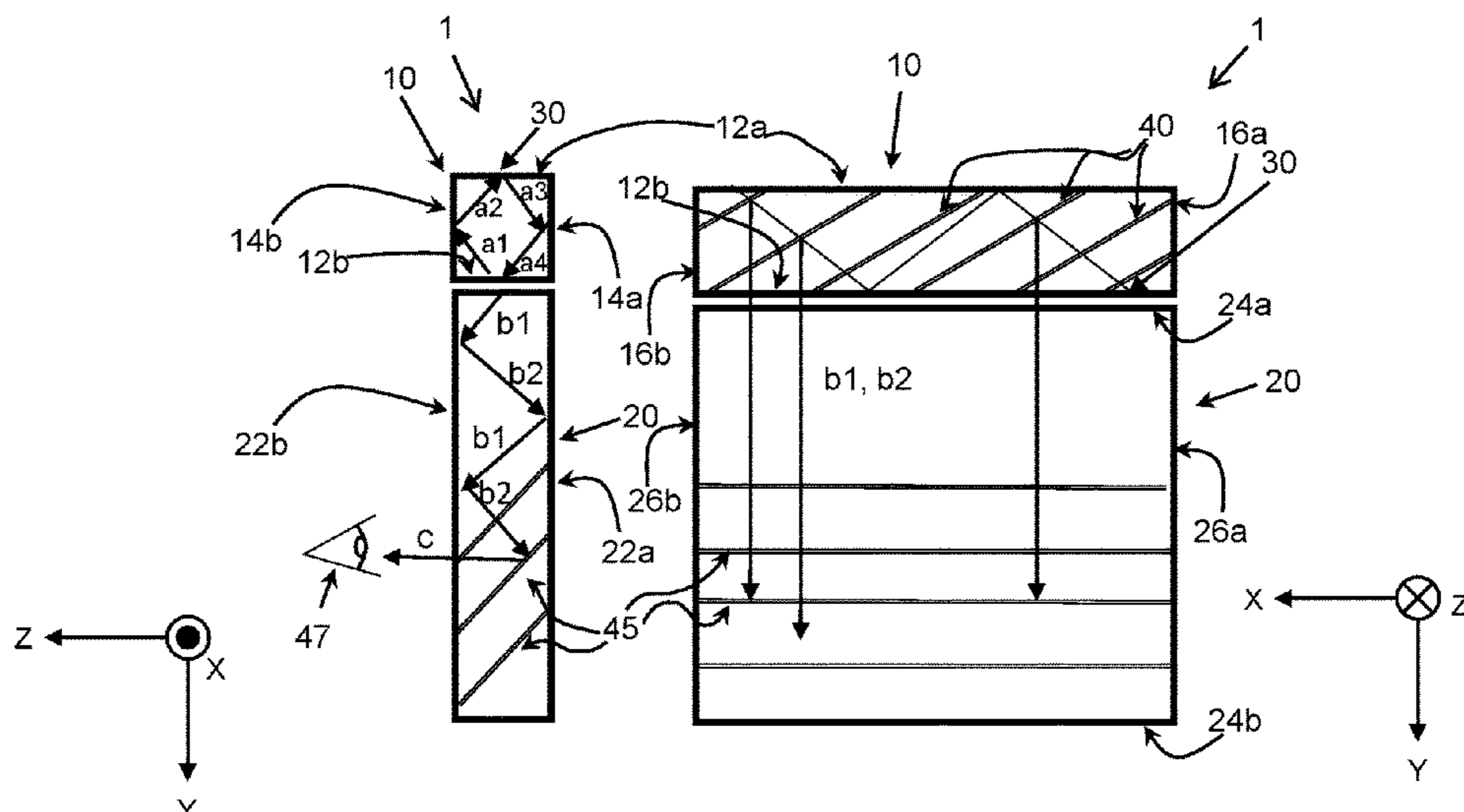
(51) **Int. Cl.**

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**G02F 1/295** (2006.01)  
**F21V 8/00** (2006.01)  
**G02B 27/00** (2006.01)

(52) **U.S. Cl.**

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**24 Claims, 9 Drawing Sheets**



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See application file for complete search history.

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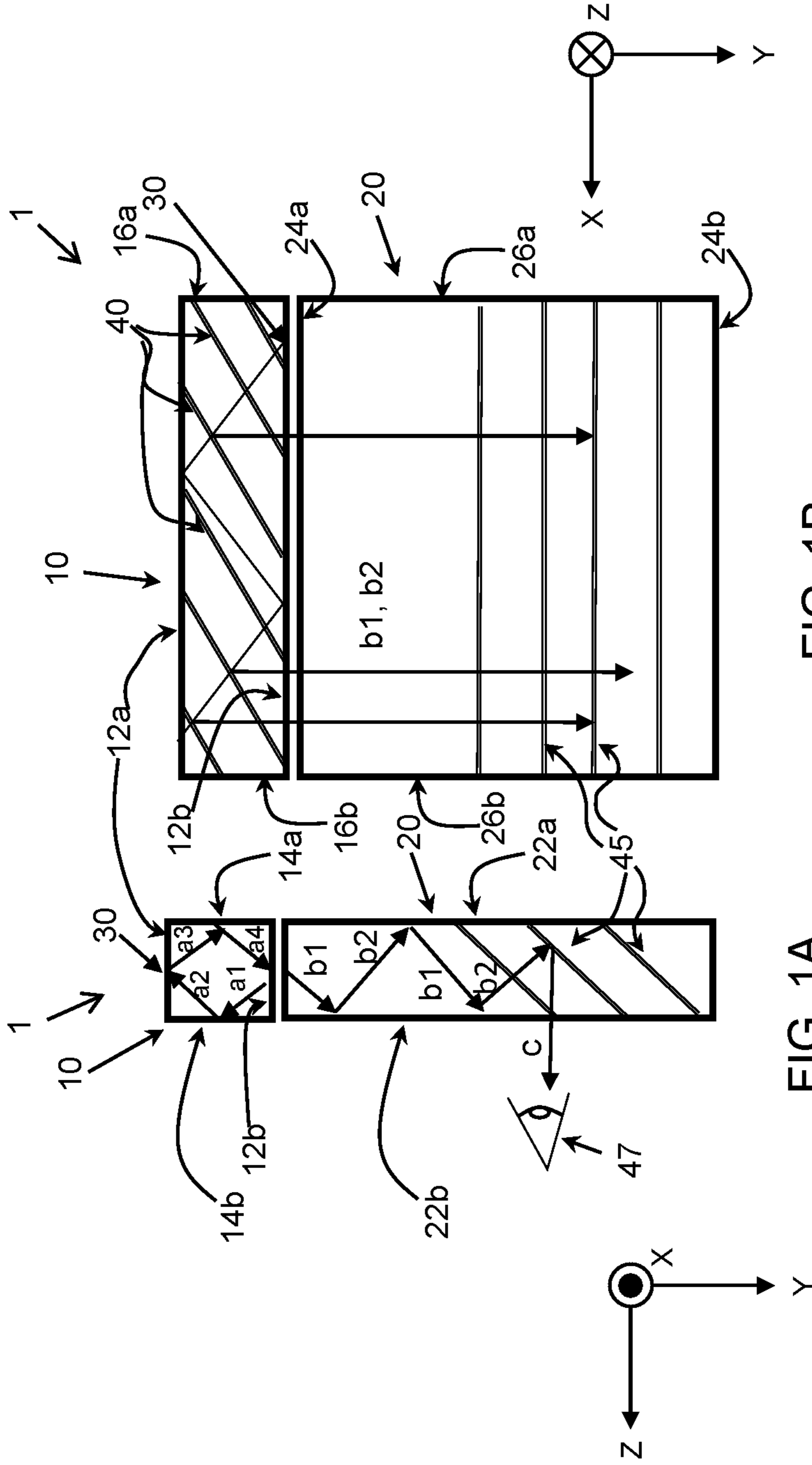


FIG. 1B

FIG. 1A

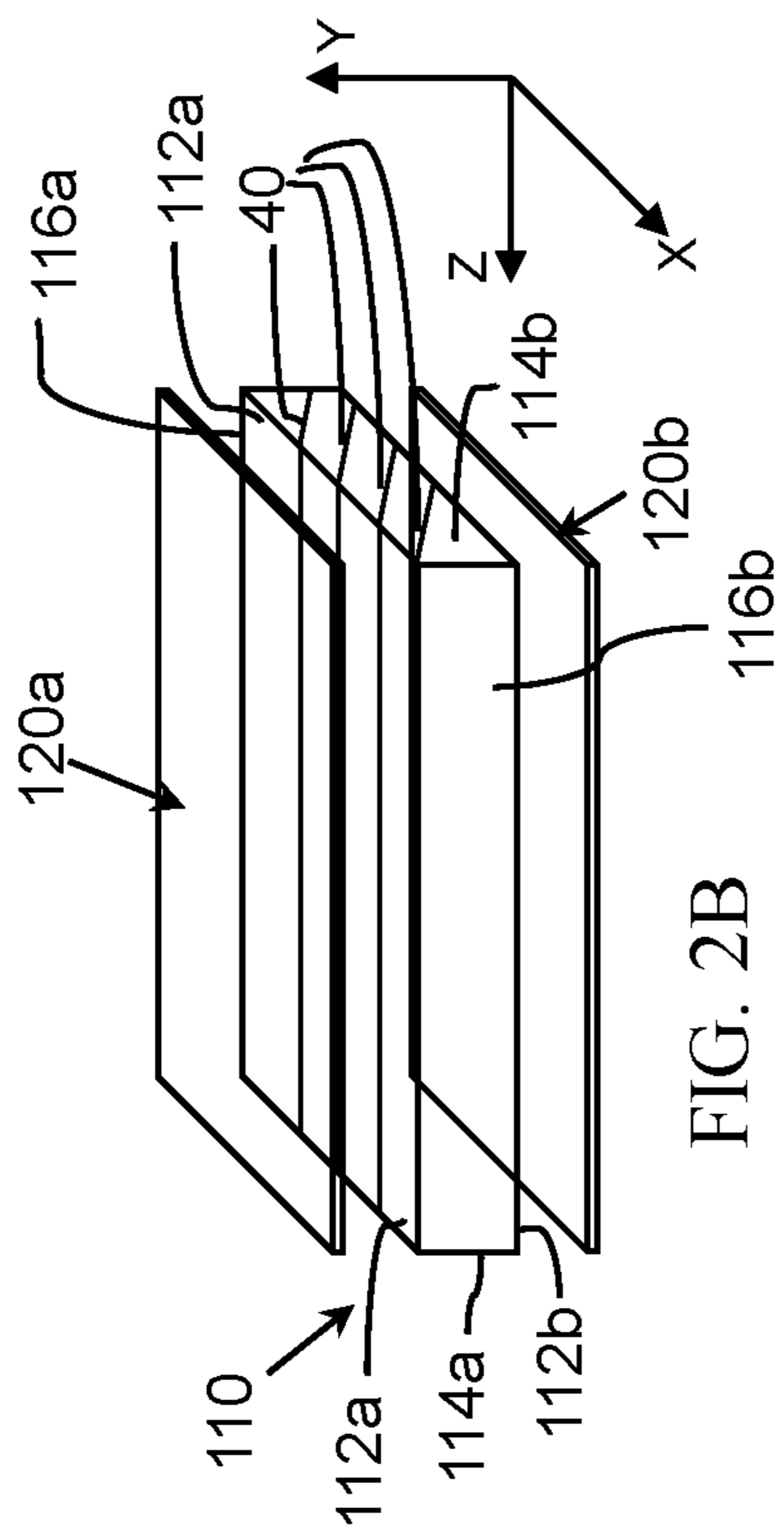


FIG. 2A

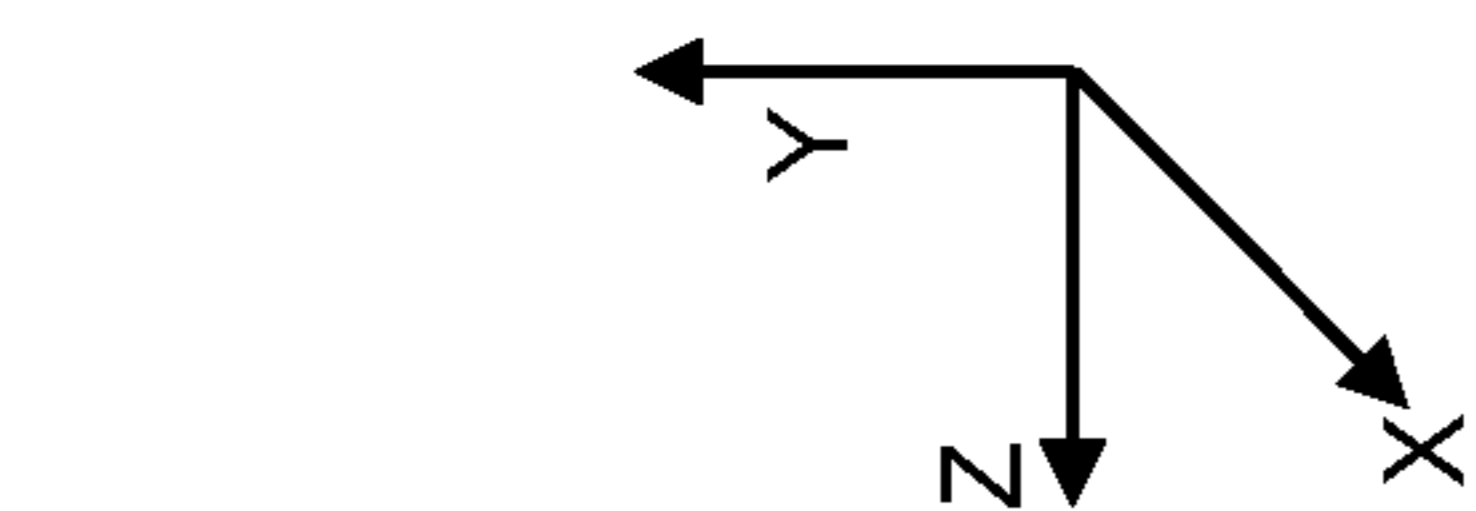


FIG. 2B

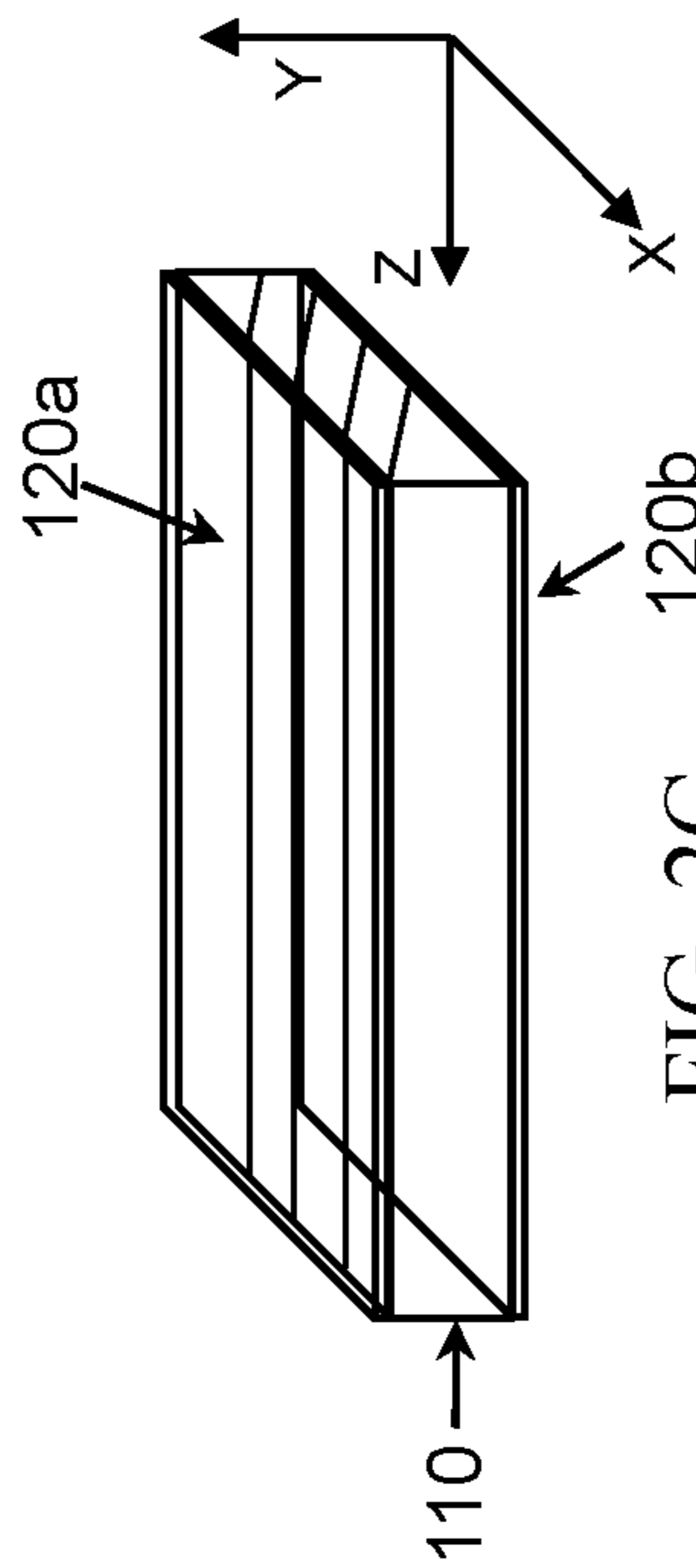


FIG. 2C

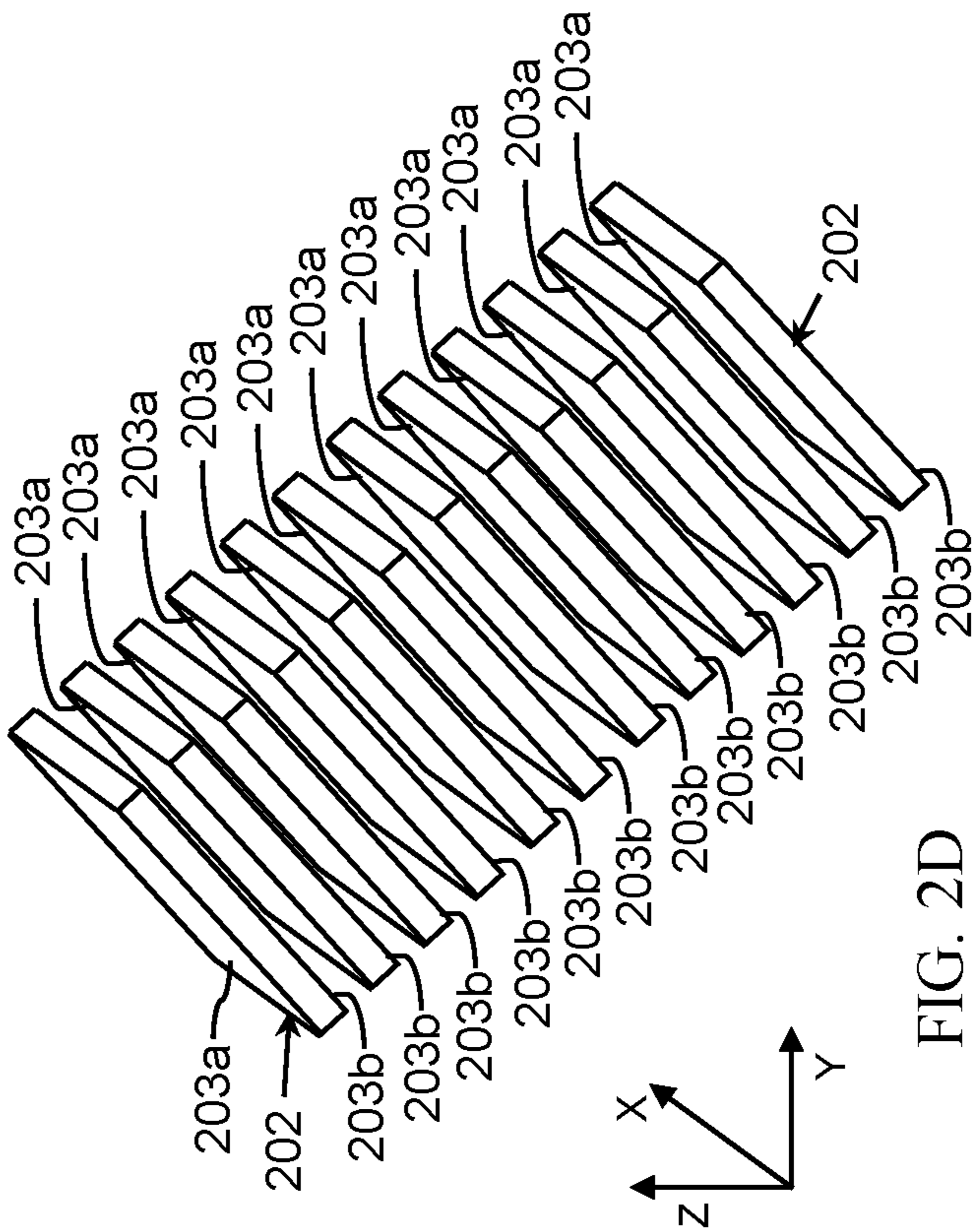
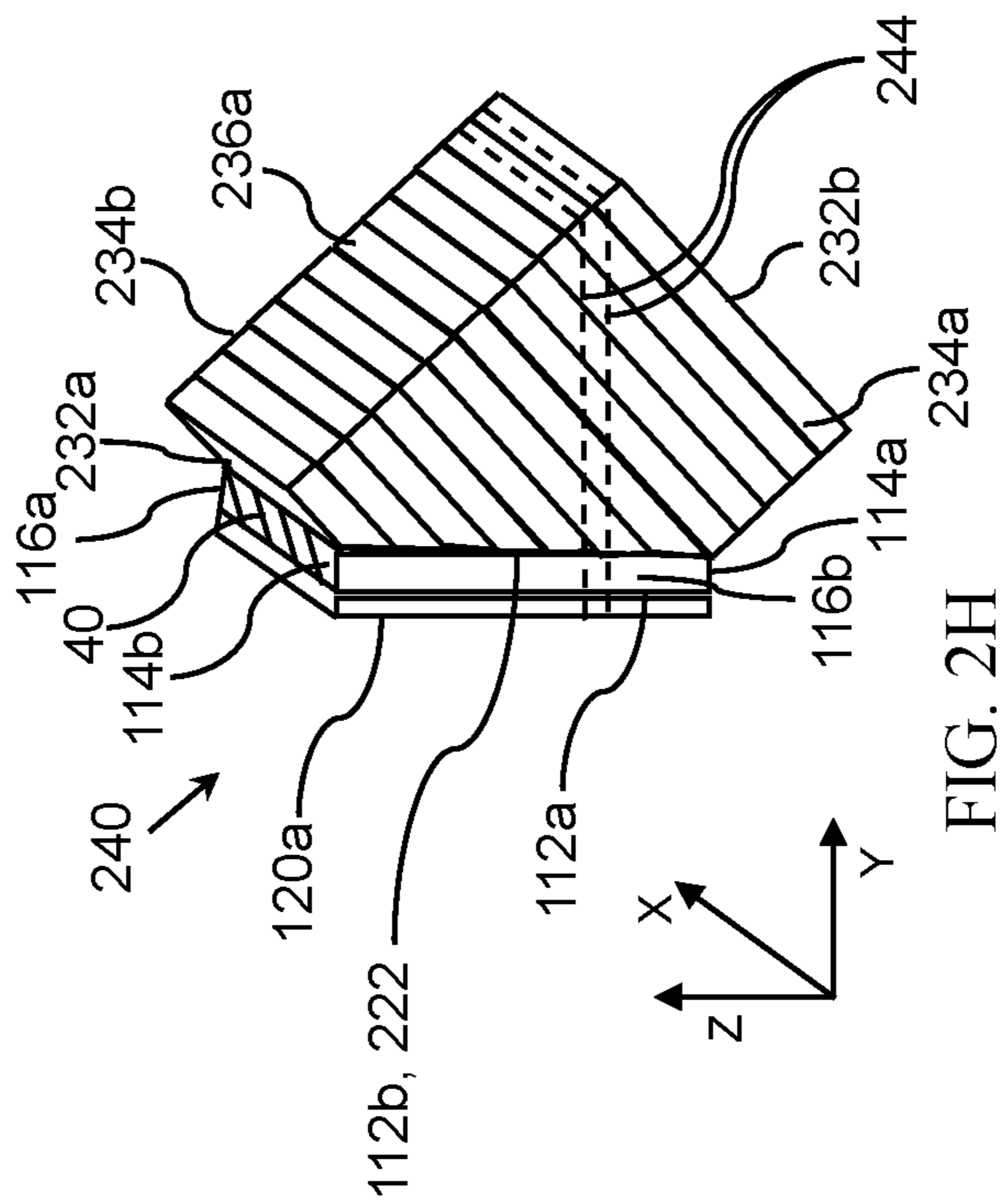
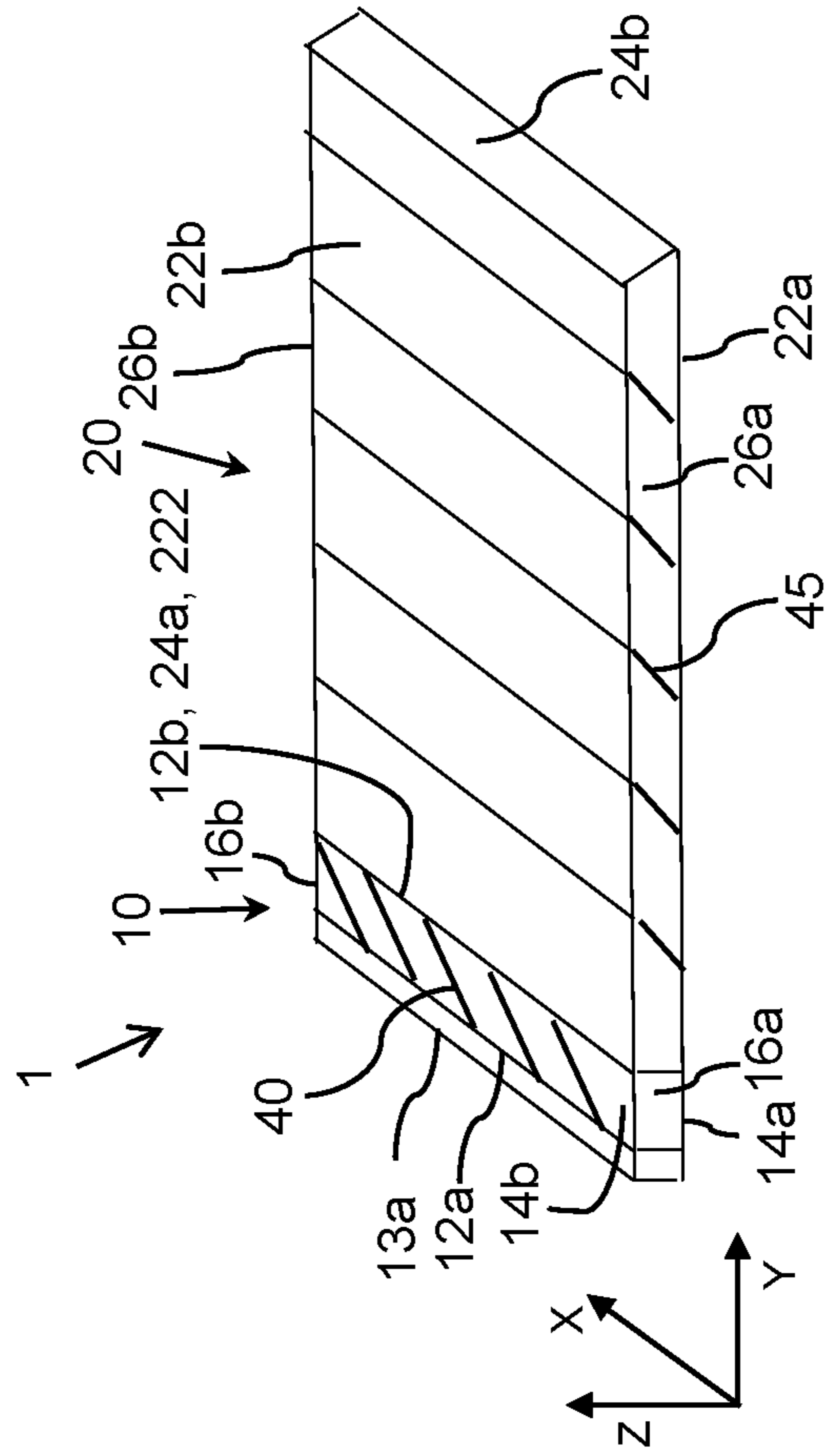


FIG. 2D





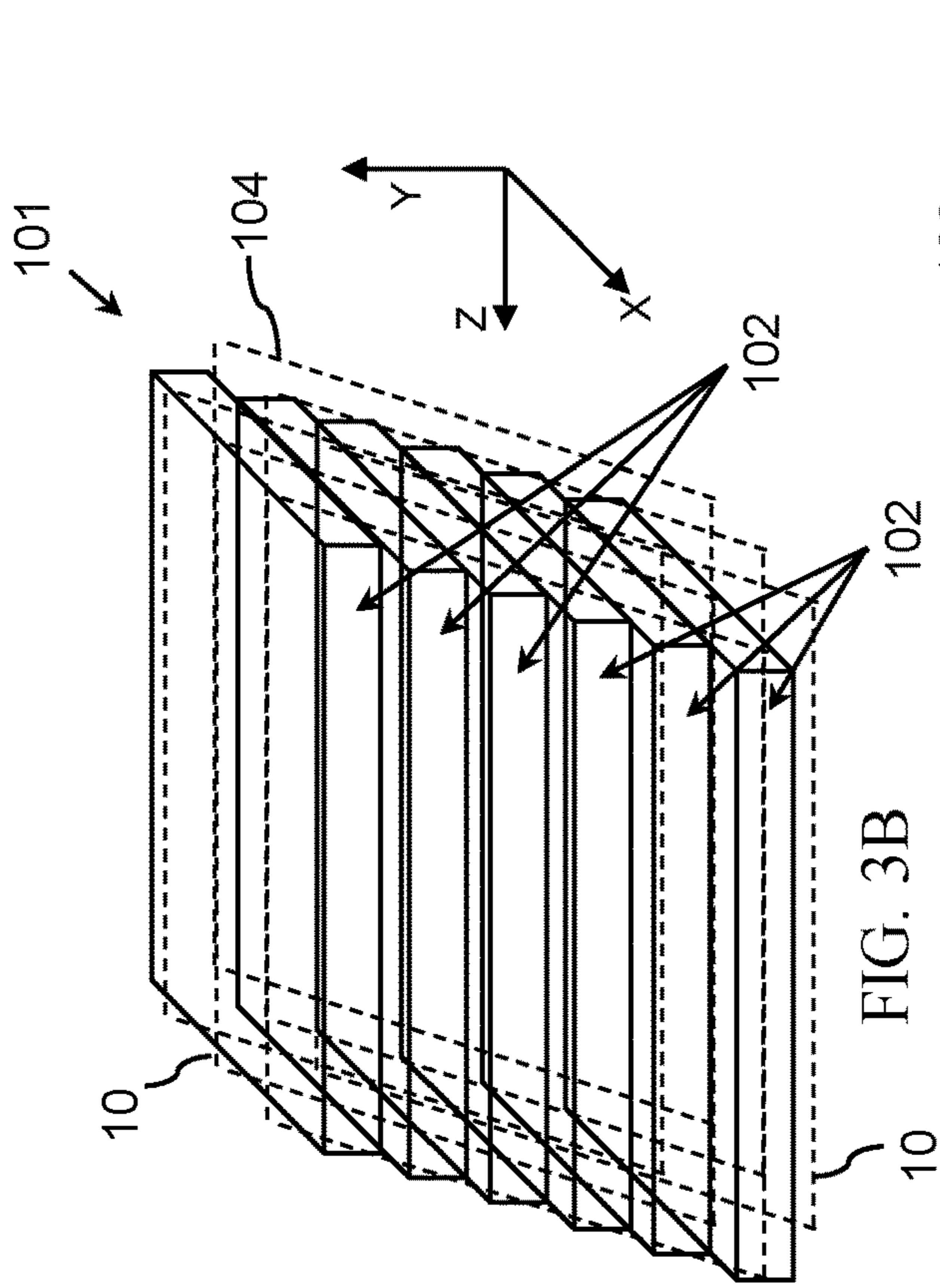


FIG. 3B

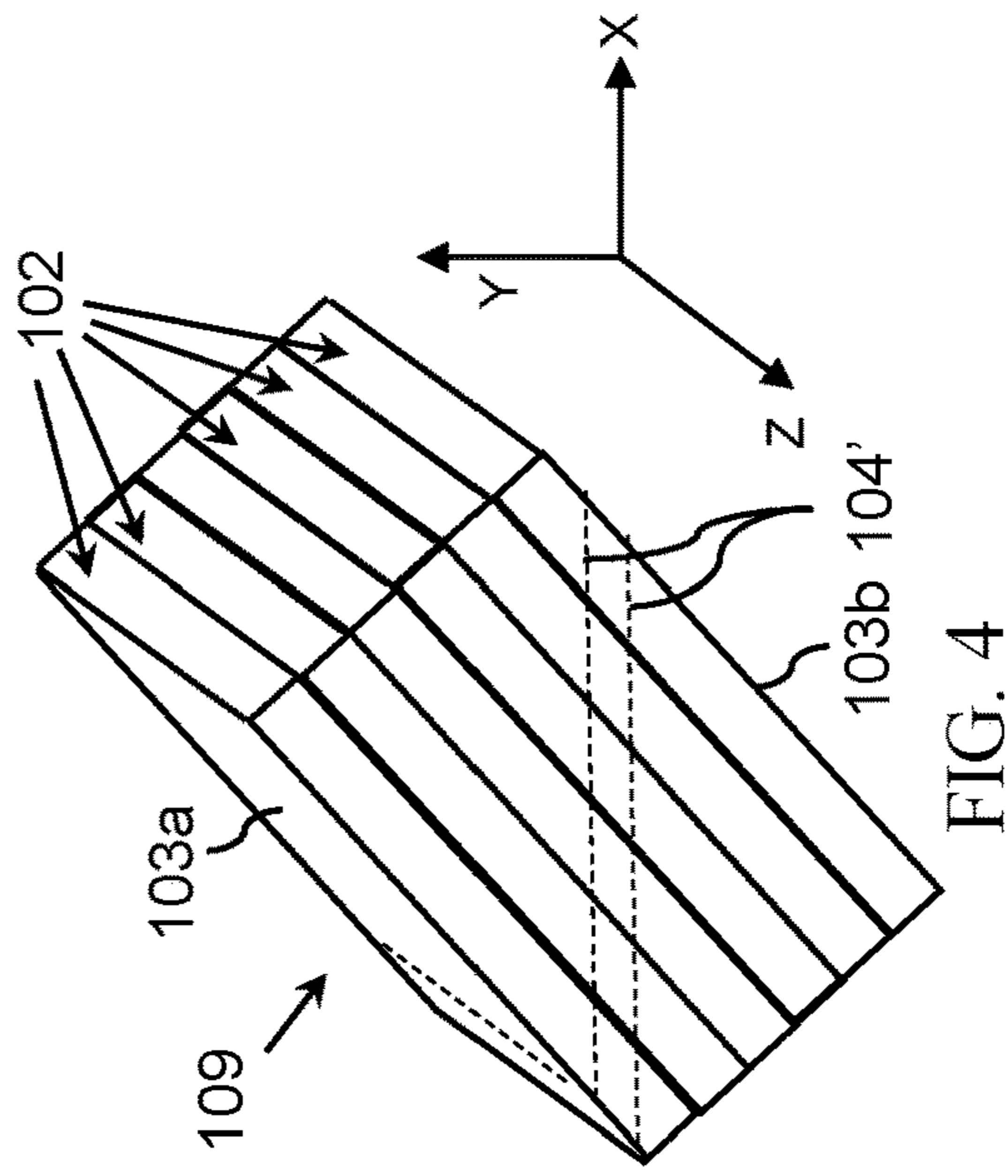


FIG. 4

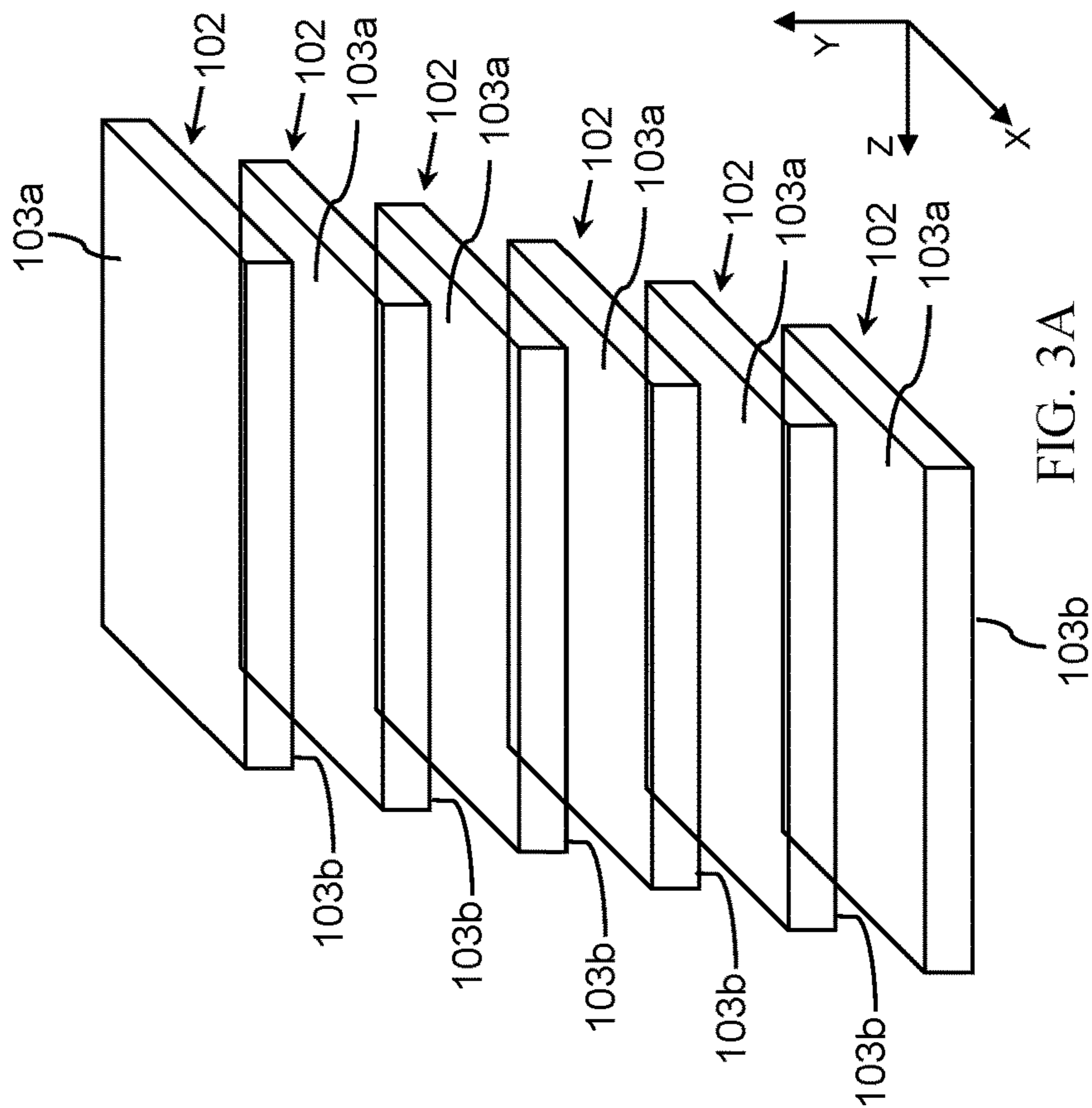
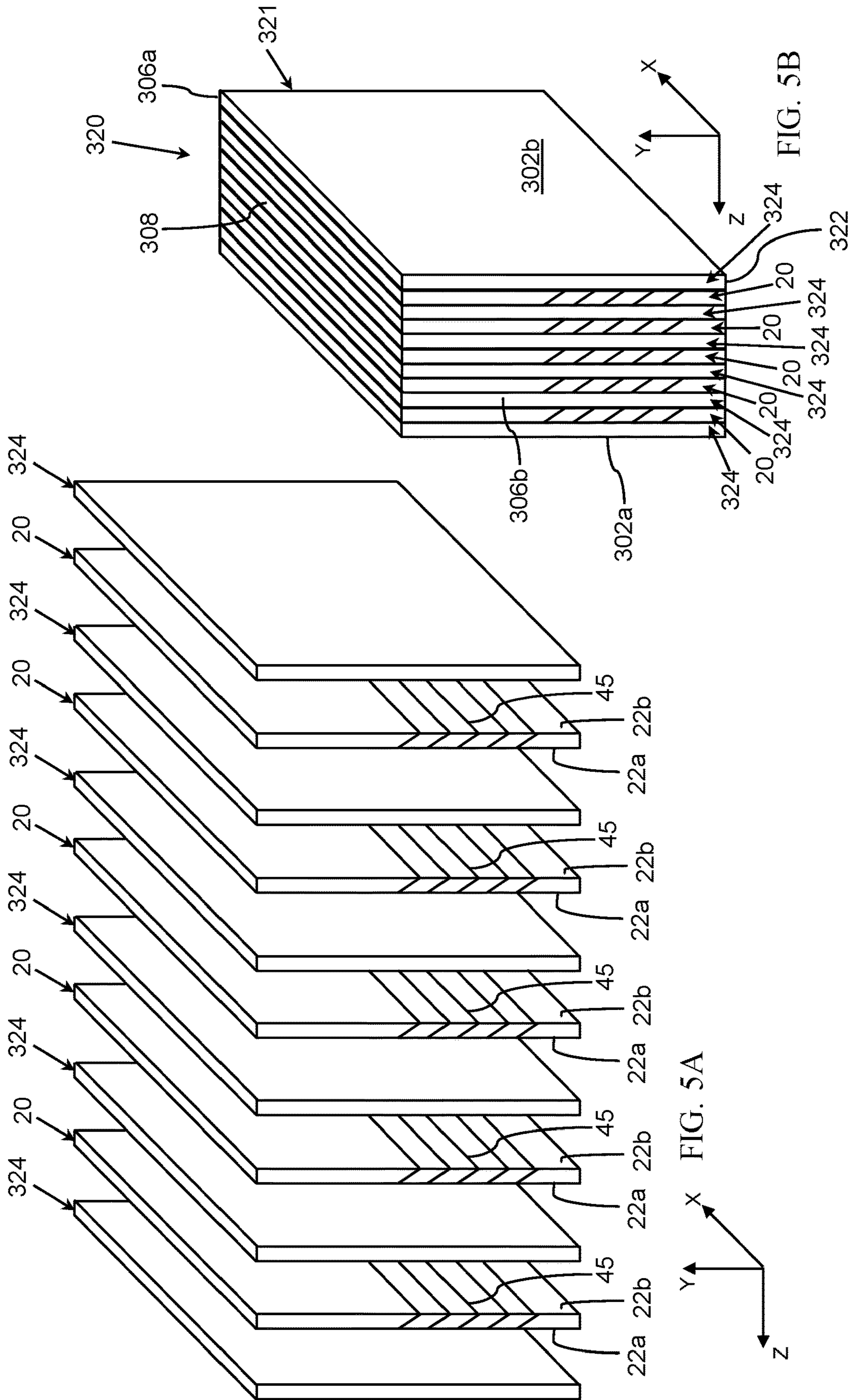
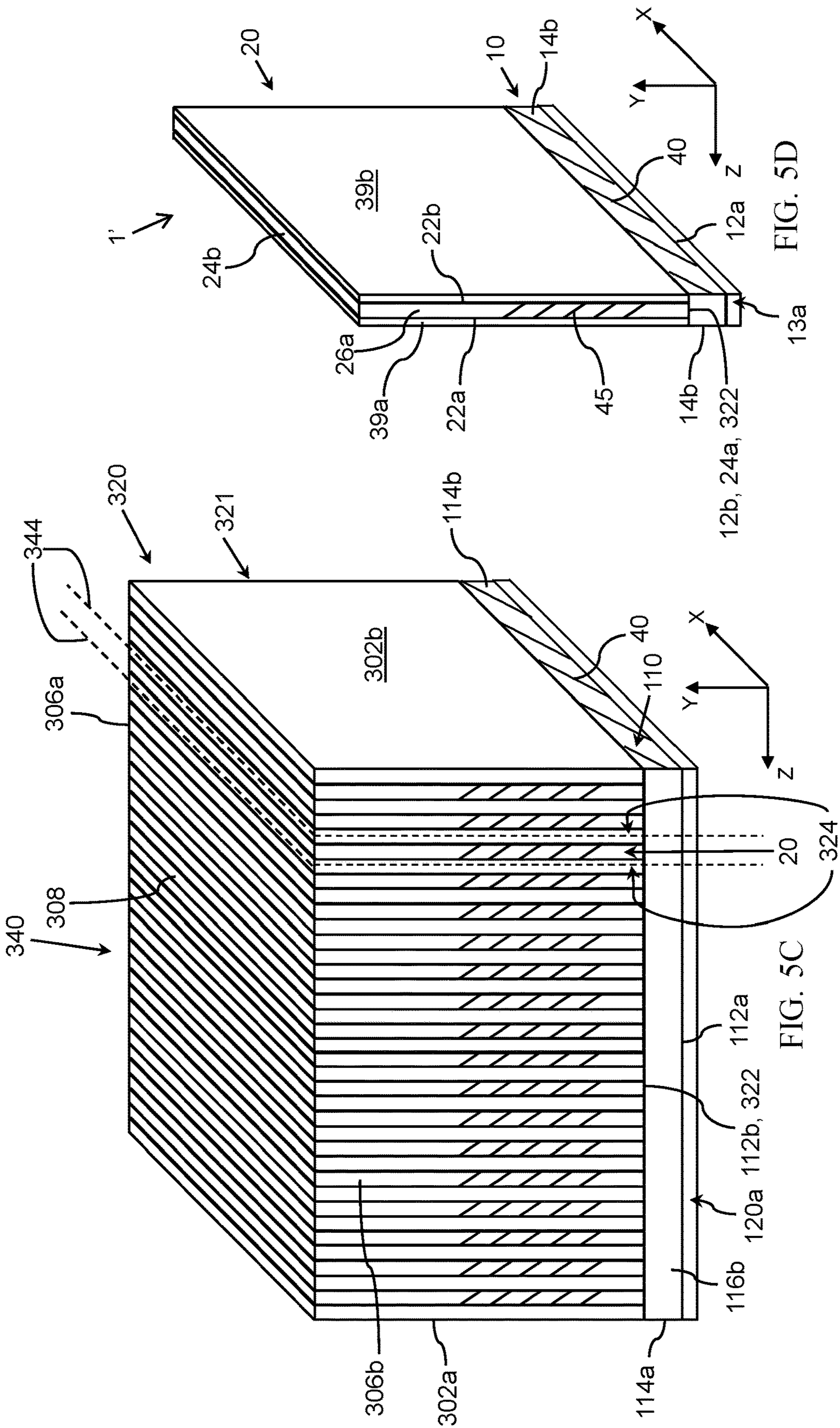
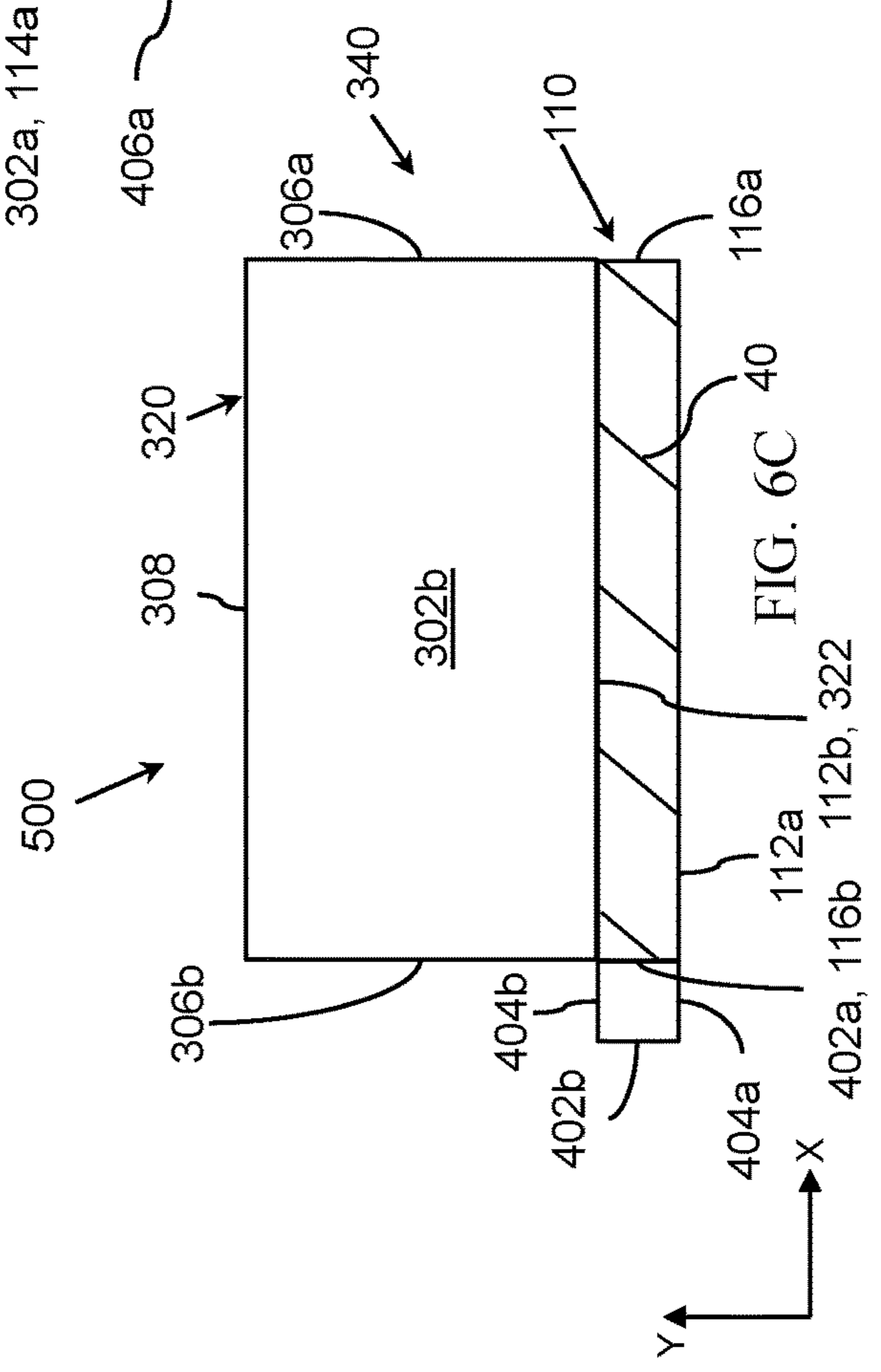
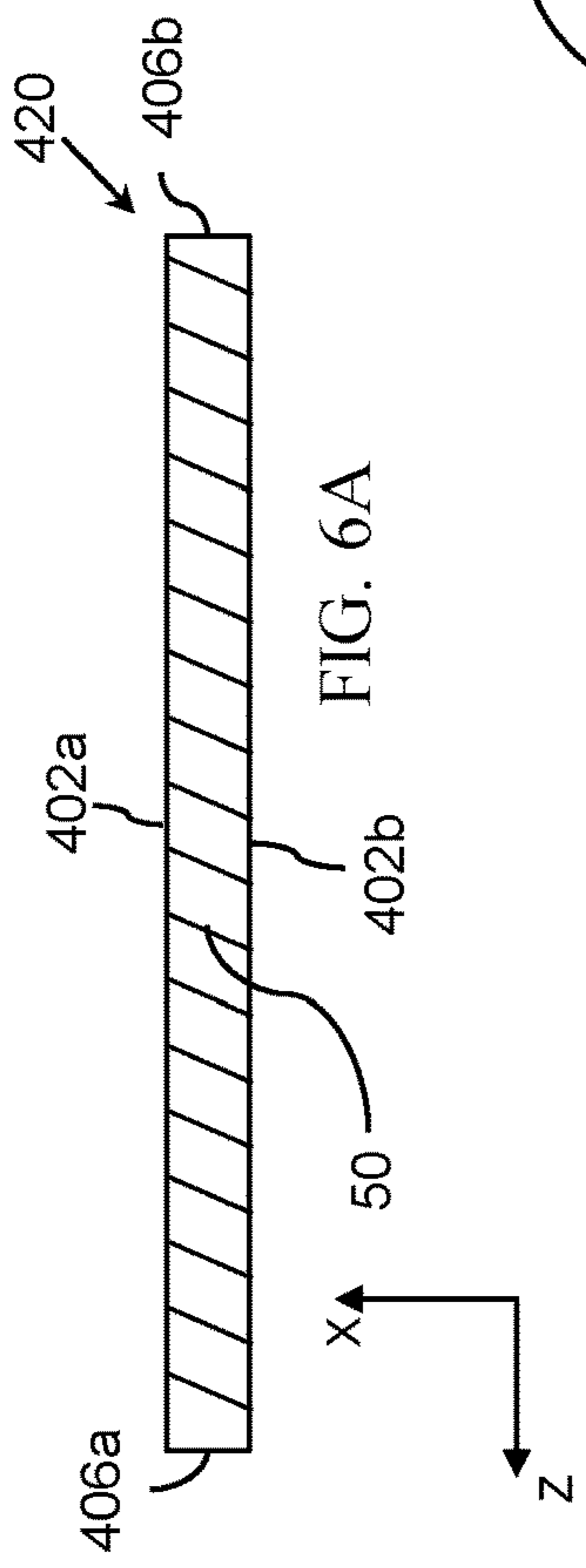
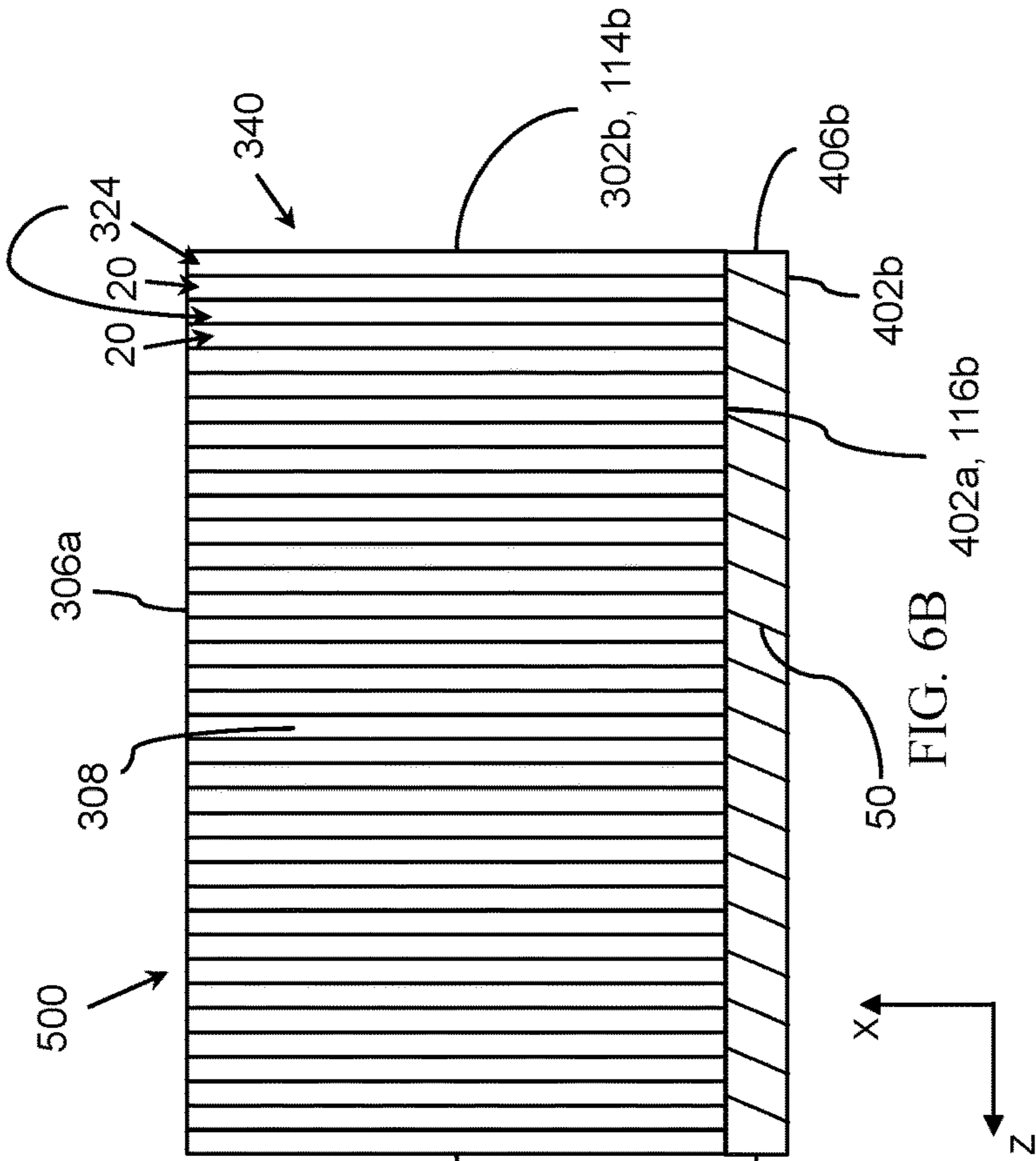


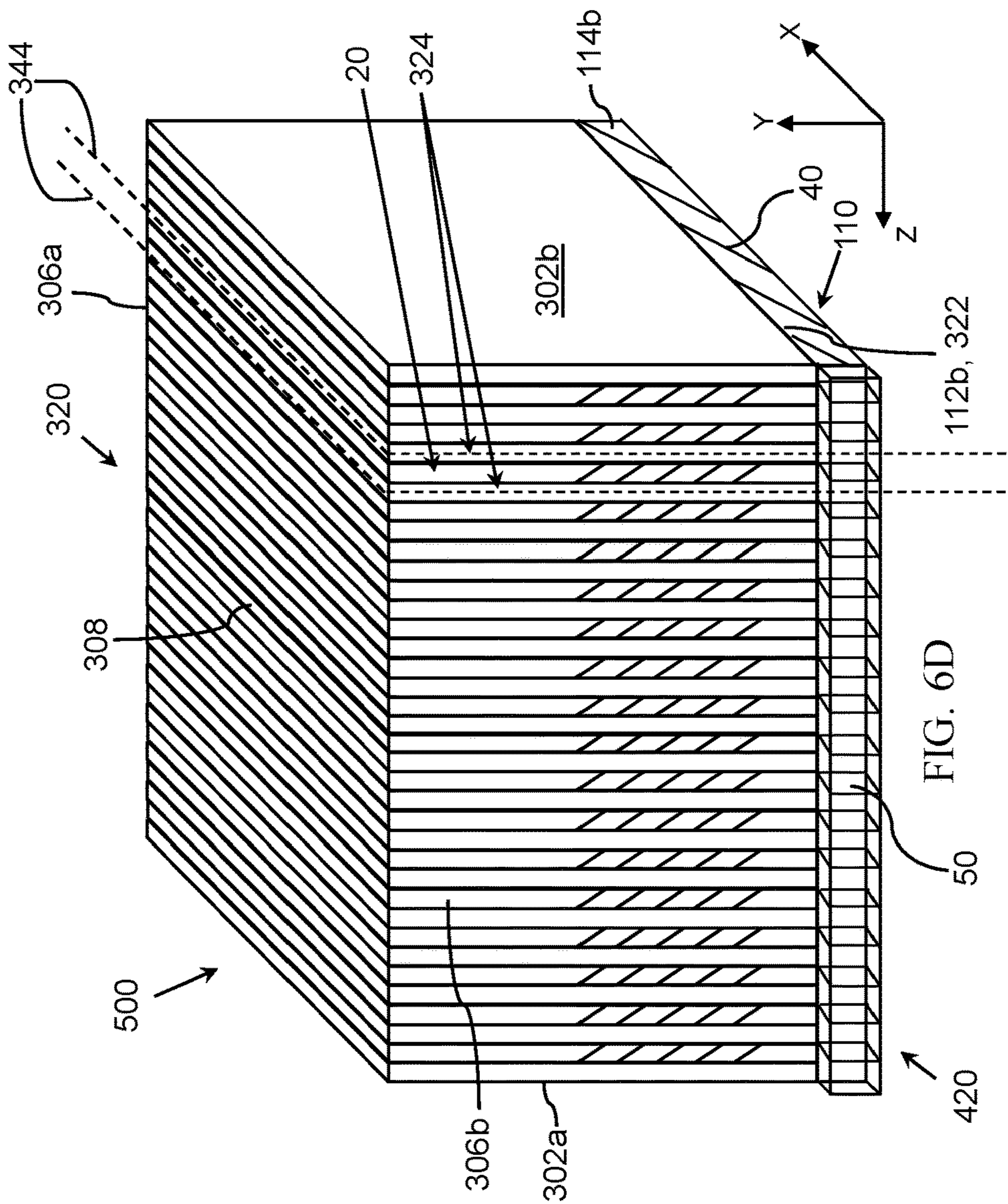
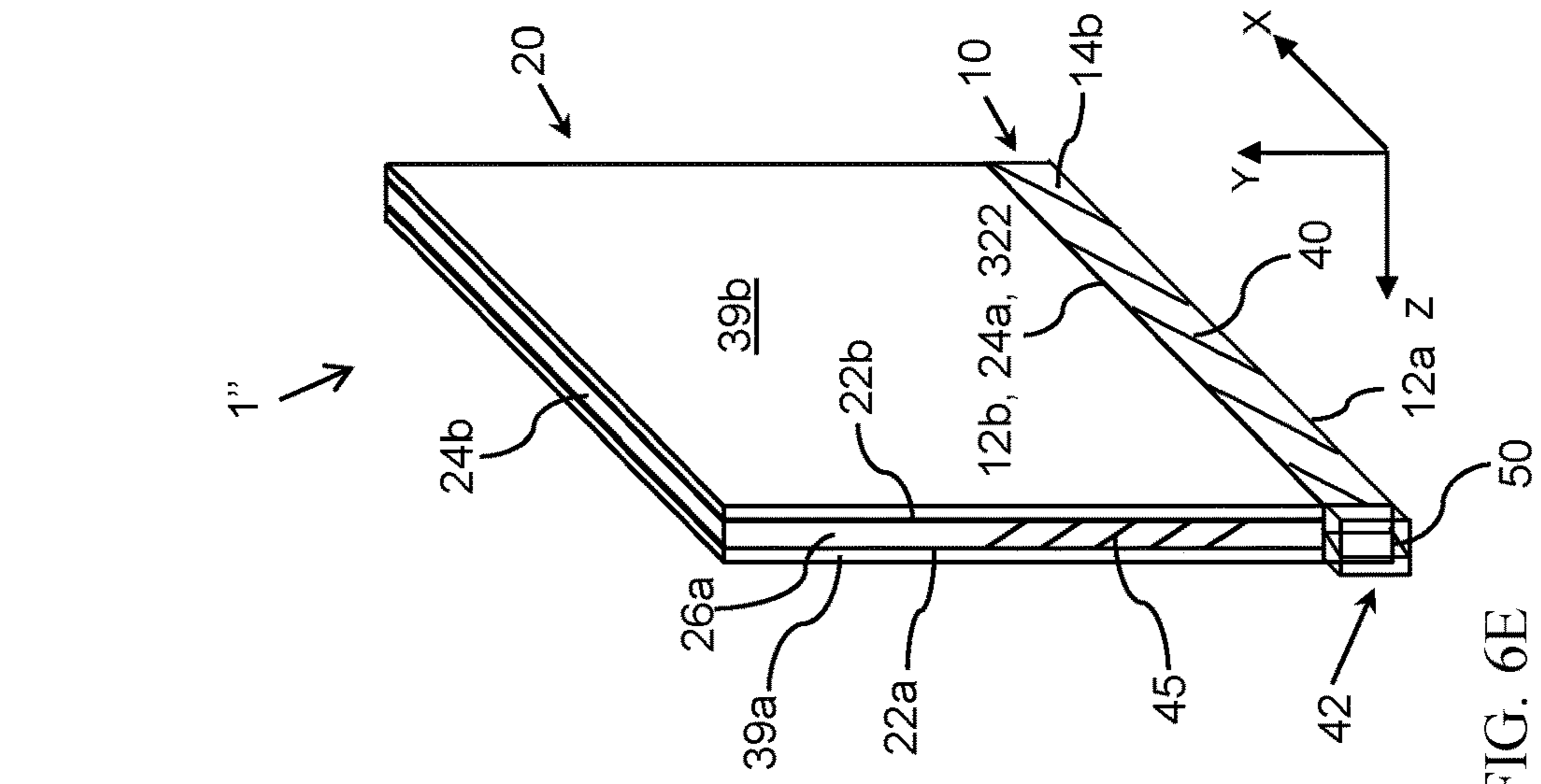
FIG. 3A











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**METHODS OF FABRICATION OF OPTICAL  
APERTURE MULTIPLIERS HAVING  
RECTANGULAR WAVEGUIDE**

CROSS-REFERENCE TO RELATED  
APPLICATIONS

This application claims priority from U.S. Provisional Patent Application No. 63/197,452, filed Jun. 7, 2021, the disclosure of which is incorporated by reference in its entirety herein.

TECHNICAL FIELD

The present invention relates to optical aperture multipliers, and in particular, optical aperture multipliers that include a rectangular optical waveguide optically coupled with thin slab-type optical waveguides.

BACKGROUND OF THE INVENTION

Optical arrangement for near eye display or head up display require large aperture to cover the area where the eye of the observer is located. Optical devices that provide two-dimensional optical aperture expansion (or multiplication) have been described in various publications by Lumus Ltd (Israel). In one particular set of such optical devices, two-dimensional aperture expansion is achieved by way of two optical waveguides. The first optical waveguide has two pairs of parallel faces that form a rectangular cross-section, and the second optical waveguide, in the form of a thin slab, is optically coupled to the first (rectangular) waveguide and has a pair of parallel major external faces. The two waveguides cooperate to expand the aperture of an injected image in two dimensions, where the first waveguide expands the aperture in a first dimension, and the second waveguide expands the aperture in a second dimension and couples the expanded-aperture image out to be viewed by an eye of a viewer.

In order to maintain image quality, there is a strict requirement for parallelism of the faces of the waveguides and perpendicularity between the two pairs of faces of the rectangular waveguide, as deviations from parallelism and/or perpendicularity can degrade image quality. This requirement for parallelism and perpendicularity can impose strict manufacturing requirements, resulting in higher-cost fabrication processes.

SUMMARY OF THE INVENTION

Embodiments of the present invention provide methods/processes of fabrication of optical aperture multipliers that have rectangular waveguides and optical structures that are intermediate work products in such fabrication methods/processes.

According to the teachings of an embodiment of the present invention, there is provided a method of fabricating an optical aperture multiplier. The method comprises: obtaining a slice having a plurality of external faces including a pair of parallel faces, and a first plurality of mutually parallel partially reflective internal surfaces oblique to the pair of parallel faces; obtaining a first optical structure having a plurality of external surfaces including a planar coupling surface, and a second plurality of mutually parallel partially reflective internal surfaces oblique to the coupling surface; optically coupling the slice with the first optical structure such that one of the faces of the pair of parallel

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faces is brought into facing relation with the coupling surface, thereby forming a second optical structure; and slicing out at least one optical aperture multiplier from the second optical structure by cutting the second optical structure through at least two cutting planes that are perpendicular to the coupling surface.

Optionally, the first optical structure is produced from a bonded stack of coated transparent plates.

Optionally, the bonded stack has a pair of faces, and the first optical structure is produced from the bonded stack by cutting the bonded stack along a cutting plane that is at an angle relative to at least one of the faces of the pair of faces of the bonded stack.

Optionally, the first optical structure is produced from the bonded stack by further polishing or slicing at the location of the cutting plane to form the coupling surface.

Optionally, the first optical structure is formed as a bonded stack of light-guide optical elements (LOEs), each LOE of the bonded stack having a pair of major parallel surfaces and a subset of the second plurality of mutually parallel partially reflective internal surfaces oblique to the pair of major parallel surfaces.

Optionally, the at least two cutting planes are substantially parallel to the major parallel surfaces of consecutive LOEs.

Optionally, the bonded stack includes a plurality of transparent spacer plates, and the LOEs and the transparent spacer plates alternate along a length of the bonded stack perpendicular to the major parallel surfaces of the LOEs.

Optionally, the at least two cutting planes are located in consecutive spacer plates having one of the LOEs sandwiched therebetween.

Optionally, the method further comprises: obtaining a third optical structure having a plurality of external faces including a coupling face, and a plurality of mutually parallel internal surfaces oblique to the coupling face; and prior to slicing out the at least one optical aperture multiplier, optically coupling the third optical structure with the slice such that coupling face of the third optical structure is brought into facing relation with one of the external faces of the slice.

There is also provided according to an embodiment of the teachings of the present invention a method of fabricating an optical aperture multiplier. The method comprises: obtaining a slice having a plurality of external faces including a pair of parallel faces and a plurality of mutually parallel partially reflective internal surfaces oblique to the pair of parallel faces; producing from a bonded stack of coated transparent plates a first optical structure having a plurality of external surfaces including a coupling surface oblique to major surfaces of the coated transparent plates; optically coupling the slice with the first optical structure such that one of the faces of the pair of parallel faces is brought into facing relation with the coupling surface, thereby forming a second optical structure; and slicing out at least one optical aperture multiplier from the second optical structure by cutting the second optical structure through at least two cutting planes that are perpendicular to the coupling surface.

Optionally, the bonded stack has a pair of faces, and producing the first optical structure from the bonded stack includes cutting the bonded stack along a cutting plane that is at an angle relative to at least one of the faces of the pair of faces of the bonded stack.

Optionally, producing the first optical structure from the bonded stack further includes polishing at the location of the cutting plane to form the coupling surface.

There is also provided according to an embodiment of the teachings of the present invention a method of fabricating an

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optical aperture multiplier. The method comprises: obtaining a bonded stack of light-guide optical elements (LOEs), each LOE of the bonded stack having a pair of major parallel surfaces and a first plurality of mutually parallel partially reflective internal surfaces oblique to the pair of major parallel surfaces; obtaining a slice having a plurality of external faces including a pair of parallel faces and a second plurality of mutually parallel partially reflective internal surfaces oblique to the pair of parallel faces; optically coupling the slice with the bonded stack such that one of the faces of the pair of parallel faces is brought into facing relation with a coupling surface of the bonded stack and such that the pair of parallel faces are perpendicular to the pair of major parallel surfaces of each of the LOEs of the bonded stack, thereby forming an optical structure; and slicing out at least one optical aperture multiplier from the optical structure by cutting the optical structure through at least two cutting planes that are substantially parallel to the major parallel surfaces of consecutive LOEs and perpendicular to the coupling surface of the bonded stack.

Optionally, the bonded stack includes a plurality of transparent spacer plates, and the LOEs and the transparent spacer plates alternate along a length of the bonded stack perpendicular to the major parallel surfaces of the LOEs.

Optionally, the at least two cutting planes are located in consecutive spacer plates having one of the LOEs sandwiched therebetween.

Optionally, any one of the methods according to embodiments of the present invention further comprises: optically coupling a cover plate with the slice at one or more of the faces of the pair of parallel faces.

Optionally, the cover plate includes a reflective coating.

Optionally, the optically coupling the cover plate with the slice includes bonding the cover plate with one or more of the faces of the pair of parallel faces.

Optionally, the bonding is performed using an optical cement having a refractive index that is lower than a refractive index of a material used to produce the slice.

Optionally, the cover plate is optically coupled with the slice at the one of the faces of the pair of parallel faces that is brought into facing relation with the coupling surface, and the cover plate has polarization managing properties.

Optionally, the cover plate includes at least one of a waveplate or a polarizer.

There is also provided according to an embodiment of the teachings of the present invention an optical structure that is an intermediate work product of an optical aperture multiplier fabrication process. The optical structure comprises: a first portion comprising a plurality of external faces including a pair of parallel faces, and a first plurality of mutually parallel partially reflective internal surfaces oblique to the pair of parallel faces; and a second portion comprising a plurality of external surfaces including a coupling surface, and a second plurality of mutually parallel partially reflective internal surfaces oblique to the coupling surface, the second portion is optically coupled with the first portion such that one of the faces of the pair of parallel faces is in facing relation with the coupling surface and such that at least one optical aperture multiplier is produced when the optical structure is sliced through at least two substantially parallel cutting planes that pass through the first portion and the second portion and are perpendicular to the coupling surface.

Optionally, the second portion is formed from a bonded stack of coated transparent plates.

Optionally, the second portion is formed as a bonded stack of light-guide optical elements (LOEs), each LOE of the bonded stack having a pair of major parallel surfaces and a

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subset of the second plurality of mutually parallel partially reflective internal surfaces oblique to the pair of major parallel surfaces.

Optionally, the bonded stack includes a plurality of transparent spacer plates, and the LOEs and the transparent spacer plates alternate along a length of the bonded stack perpendicular to the major parallel surfaces of the LOEs.

Optionally, the optical structure further comprises: a third portion having a plurality of external faces including a coupling face, and a plurality of mutually parallel internal surfaces oblique to the coupling face, the third portion is optically coupled with the first portion such that coupling face of the third portion is in facing relation with one of the external faces of the first portion.

There is also provided according to an embodiment of the teachings of the present invention an optical structure that is an intermediate work product of an optical aperture multiplier fabrication process. The optical structure comprises: a first portion having a plurality of external faces including a pair of parallel faces and a plurality of mutually parallel partially reflective internal surfaces oblique to the first pair of parallel faces; and a second portion, formed from a bonded stack of coated transparent plates, having a plurality of external surfaces including a coupling surface oblique to major surfaces of the coated transparent plates, the first portion optically coupled with the second portion such that one of the faces of the pair of parallel faces is in facing relation with the coupling surface and such that at least one optical aperture multiplier is produced when the optical structure is sliced through at least two substantially parallel cutting planes that pass through the first and second portions and are perpendicular to the coupling surface.

Optionally, the bonded stack has a pair of faces, and the second portion is formed by cutting the bonded stack along a cutting plane that is at an angle relative to at least one of the faces of the pair of faces of the bonded stack.

Optionally, the coupling surface is formed by polishing the second portion at the location of the cutting plane.

There is also provided according to an embodiment of the teachings of the present invention an optical structure that is an intermediate work product of an optical aperture multiplier fabrication process. The optical structure comprises: a second portion comprising a plurality of external faces including a pair of parallel faces, and a second plurality of mutually parallel partially reflective internal surfaces oblique to the pair of parallel faces; and a second portion comprising a bonded stack of light-guide optical elements (LOEs), each LOE of the bonded stack having a pair of major parallel surfaces and a first plurality of mutually parallel partially reflective internal surfaces oblique to the pair of major parallel surfaces, the first portion is optically coupled with the second portion such that one of the faces of the pair of parallel faces is in facing relation with a coupling surface of the second portion and such that the pair of parallel faces are perpendicular to the pair of major parallel surfaces of each of the LOEs of the bonded stack.

Optionally, the bonded stack includes a plurality of transparent spacer plates, and the LOEs and the transparent spacer plates alternate along a length of the bonded stack perpendicular to the major parallel surfaces of the LOEs.

Optionally, any one of the intermediate work products according to embodiments of the present invention further comprises: a cover plate optically coupled with the first portion at one or more of the faces of the pair of parallel faces.

Optionally, the cover plate includes a reflective coating.

Optionally, the cover plate is optically coupled with the first portion by bonding the cover plate to one of the faces of the pair of parallel faces.

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Optionally, the bonding is performed using an optical cement having a refractive index that is lower than a refractive index of a material used to produce the first portion.

Optionally, the cover plate is optically coupled with the first portion at the one of the faces of the pair of parallel faces that is in facing relation with the coupling surface, and the cover plate has polarization managing properties.

Optionally, the cover plate includes at least one of a waveplate or a polarizer.

Unless otherwise defined herein, all technical and/or scientific terms used herein have the same meaning as commonly understood by one of ordinary skill in the art to which the invention pertains. Although methods and materials similar or equivalent to those described herein may be used in the practice or testing of embodiments of the invention, exemplary methods and/or materials are described below. In case of conflict, the patent specification, including definitions, will control. In addition, the materials, methods, and examples are illustrative only and are not intended to be necessarily limiting.

## BRIEF DESCRIPTION OF THE DRAWINGS

Some embodiments of the present invention are herein described, by way of example only, with reference to the accompanying drawings. With specific reference to the drawings in detail, it is stressed that the particulars shown are by way of example and for purposes of illustrative discussion of embodiments of the invention. In this regard, the description taken with the drawings makes apparent to those skilled in the art how embodiments of the invention may be practiced.

Attention is now directed to the drawings, where like reference numerals or characters indicate corresponding or like components. In the drawings:

FIGS. 1A and 1B are schematic side and front views, respectively, of an optical aperture multiplier having a first rectangular optical waveguide with a plurality of partially reflective internal surfaces, optically coupled with a second thin slab-type optical waveguide having a plurality of partially reflective internal surfaces, that can be fabricated using fabrication processes according to the teachings of embodiments of the present invention;

FIGS. 2A-2I are schematic isometric views illustrating a sequence of steps used in a process of fabrication of an optical aperture multiplier, such as the optical aperture multiplier of FIGS. 1A and 1B, according to a first set of embodiments of the present invention;

FIGS. 3A and 3B are schematic isometric views illustrating a sequence of steps that can be used to fabricate a slice optical structure that is used in the process of FIGS. 2A-2I, according to an embodiment of the present invention;

FIG. 4 is a schematic isometric view illustrating another technique that can be used to fabricate the slice optical structure, according to an embodiment of the present invention;

FIGS. 5A-5D are schematic isometric views illustrating a sequence of steps used in a process of fabrication of an optical aperture multiplier, according to a second set of embodiments of the present invention;

FIG. 6A is a schematic plan view of an optical structure from which multiple optical coupling-in configurations can be extracted, and that can be used in a process of fabrication of an optical aperture multiplier, according to embodiments of the present invention;

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FIGS. 6B-6D are schematic plan, front, and isometric views, respectively, of the optical structure of FIG. 6A optically coupled with another optical structure that is produced in one of the steps of the process of FIGS. 5A-5D; and

FIG. 6E is a schematic isometric view of an optical aperture multiplier that can be produced using a fabrication process according to embodiments of the present invention.

## DESCRIPTION OF THE PREFERRED EMBODIMENTS

Embodiments of the present invention provide methods/processes of fabrication of optical aperture multipliers that have rectangular waveguides and optical structures that are intermediate work products in such fabrication methods/processes.

The principles and operation of the methods and intermediate work products according to present invention may be better understood with reference to the drawings accompanying the description. The accompanying drawings are provided with an xyz coordinate system that is arbitrarily labeled but which is consistent between the drawings. This xyz coordinate system is used herein to better explain the disclosed embodiments by providing a common reference frame among the drawings.

Before explaining at least one embodiment of the invention in detail, it is to be understood that the invention is not necessarily limited in its application to the details of construction and the arrangement of the components and/or methods set forth in the following description and/or illustrated in the drawings and/or the examples. The invention is capable of other embodiments or of being practiced or carried out in various ways. Initially, throughout this document, references are made to directions, such as, for example, top and bottom, upper and lower, front and back, and the like. These directional references are exemplary only, and are used only for ease of presentation and refer to the arbitrary orientations as illustrated in the drawings. The final optical devices may be deployed in any required orientation.

By way of introduction, commonly owned U.S. Pat. No. 10,133,070, which is incorporated by reference in its entirety herein, describes various embodiments of an optical aperture multiplier **1**, shown generally in FIGS. 1A and 1B. The optical aperture multiplier **1** is particularly suitable for use as part of a near eye display or head up display for augmented reality applications. In general terms, the optical aperture multiplier **1** (also referred to as an "optical device") includes a first optical waveguide **10** having a direction of elongation (illustrated arbitrarily herein as corresponding to the "x-axis"). The first optical waveguide **10** is formed from a light-transmitting material and has first and second pairs of parallel faces **12a**, **12b**, **14a**, **14b** forming a rectangular cross-section (i.e., the first and second pairs of faces are perpendicular). The first optical waveguide **10** also has an additional pair of faces **16a**, **16b** (which may or may not be parallel faces). In certain embodiments in which the faces **16a**, **16b** are parallel faces, the faces **16a**, **16b** may be perpendicular to the first and second pairs of faces **12a**, **12b**, **14a**, **14b**. The first optical waveguide **10** has a plurality of mutually parallel partially reflective internal surfaces (also referred to as "facets") **40** that at least partially traverse the first optical waveguide **10** and are inclined obliquely to the direction of elongation of the first optical waveguide **10** (i.e., the facets are oblique to the faces **12a**, **12b**).

Throughout this document, the terms “face”, “external face”, and “external surface” are used interchangeably. As will become apparent, some of such faces are major faces (also referred to as “major external faces” or “major external surfaces”).

The optical aperture multiplier **1** also includes a second optical waveguide **20**, optically coupled with the first optical waveguide **10**, having a third pair of parallel faces **22a**, **22b**. Here too, a plurality of mutually parallel partially reflective internal surfaces (“facets”) **45** at least partially traverse the second optical waveguide **20** and are inclined obliquely to the faces **22a**, **22b**. The second optical waveguide **20** also has two additional pairs of faces **24a**, **24a**, **26a**, **26b**, each of which is non-parallel to faces **22a**, **22b**, and each of which may or may not be a pair of parallel faces. In certain embodiments, the pairs of faces **22a**, **22b**, **24a**, **24b**, **26a**, **26b** are mutually perpendicular. In certain embodiments, the facets **28** are also inclined obliquely to one or both of the faces **24a**, **24b**, however, as will be discussed, in other embodiments the facets **28** can be parallel to one or both if the faces **24a**, **24b** and/or perpendicular to one or both of the faces **26a**, **26b**.

The second optical waveguide **20** is also formed from a light-transmitting material (light-transmitting substrate), and preferably from the same material that is used to form the first optical waveguide **10** (such that the two optical waveguides **10**, **20** have the same refractive index), but forms a thin slab-type waveguide, where the distances between the pairs of faces **24a**, **24b**, **26a**, **26b** are at least an order of magnitude greater than the distance between the faces **22a**, **22b**.

The optical coupling between the optical waveguides **10**, **20** (at the interface between the faces **12b**, **24a**), and the deployment and configuration of partially reflective surfaces **40**, **45** are such that, when image light **30** (also referred to as “light beam” or “beam”) corresponding to a collimated image (generated by an optical image generator, not shown) is coupled (injected) into the first optical waveguide **10** with an initial direction of propagation at a coupling angle oblique to both the first and second pairs of parallel faces **12a**, **12b**, **14a**, **14b**, the image advances by four-fold internal reflection (images **a1**, **a2**, **a3**, **a4**) along the first optical waveguide **10**, with a proportion of intensity of the image reflected at the partially reflective surfaces **40** so as to be coupled into the second optical waveguide **20**, and then propagates through two-fold internal reflection (images **b1**, **b1**) within the second optical waveguide **20**, with a proportion of intensity of the image reflected (deflected) at the partially reflective surfaces **45** so as to be directed outwards from one of the parallel faces **22b** as a visible image **c**, seen by the eye **47** of a viewer. The first optical waveguide **10** is also referred to as a two-dimensional (2D) waveguide in the sense that it guides the injected image in two dimensions by reflection between two sets of parallel faces (**12a**, **12b**, **14a**, **14b**), while the second optical waveguide **20** is also referred to as a one-dimensional (1D) waveguide in the sense that it guides the injected image in only one dimension between one pair of parallel faces (**22a**, **22b**). The second optical waveguide **20** is also referred to interchangeably herein as a light-guide optical element (LOE) or 1D LOE.

U.S. Pat. No. 10,133,070 further describes processes of fabrication of the optical aperture multiplier **1**. These processes rely on individually manufacturing the two optical waveguides **10**, and then coupling together the two individual waveguides **10**, **20** to produce an individual optical

aperture multiplier. However, such fabrication processes make large-scale production of the optical aperture multipliers more challenging.

Embodiments of the present invention provide processes which may be used to fabricate the optical aperture multiplier **1**. As will become apparent from the following description, the fabrication processes according to embodiments of the present invention enable large-scale production of optical aperture multipliers, that are particularly suitable for use as part of a near eye display or head up display for augmented reality applications, while maintaining perpendicularity and parallelism over large optical surfaces, thereby enabling tighter manufacturing tolerances.

In a first set of embodiments, as will be described with reference to FIGS. **2A-2I**, a bonded stack of coated transparent plates is obtained. The coated surfaces of the transparent plates form a plurality of mutually parallel partially reflective internal surfaces (which ultimately form the facets **45**). The bonded stack is cut along a cutting plane to form an optical structure having a plurality of external surfaces that includes a coupling surface oblique to the major surfaces of the coated transparent plates (i.e., the coupling surface is oblique to the partially reflective internal surfaces **45**). A slice (which itself is an optical structure) having a pair of external parallel faces and a plurality of mutually parallel partially reflective internal surfaces (which ultimately form the facets **40**) oblique to the pair of parallel faces is optically coupled with the optical structure at the coupling surface to form a second optical structure. This second optical structure is then sliced along two or more parallel cutting planes that are perpendicular to the coupling surface in order to extract one or more optical aperture multipliers **1**.

In a second set of embodiments, as will be described with reference to FIGS. **5A-5D**, a bonded stack of LOEs **20** is obtained. This bonded stack of LOEs constitutes a first optical structure that has a coupling surface that is oblique to the facets **45** of the LOEs **20** (and is also perpendicular to the faces **22a**, **22b** of the LOEs **20**). Similar to as in the first set of embodiments, a slice having a pair of external parallel faces and a plurality of mutually parallel partially reflective internal surfaces (which ultimately form the facets **40**) oblique to the pair of parallel faces is optically coupled with the optical structure at the coupling surface to form a second optical structure. This second optical structure is then sliced along two or more parallel cutting planes that are perpendicular to the coupling surface in order to extract one or more optical aperture multipliers **1**. In this case, the cutting planes are parallel to the faces **22a**, **22b** of the LOEs **20**, and in certain cases may be located approximately at the faces **22a**, **22b** of the LOEs **20**. As will be discussed, in certain embodiments the bonded stack of LOEs **20** can include a plurality of transparent spacer plates in which the LOEs **20** and the spacer plates alternate along the length of the bonded stack perpendicular to the faces **22a**, **22b** of the LOEs **20**. In such embodiments, the consecutive cutting planes are located in consecutive spacer plates having one LOE sandwiched therebetween.

As will become apparent from the ensuing description, both of these sets of embodiments employ steps that generally include: 1) obtaining a slice having a pair of external parallel faces and a plurality of internal surfaces (which ultimately form the facets **40**) oblique to the pair of parallel faces; 2) obtaining a first optical structure that has: i) a plurality of external surfaces that includes a coupling surface, and ii) a coupling surface oblique to the coupling surface; 3) forming a second optical structure by optically coupling the slice with the optical structure such that one of

the faces of the pair of parallel faces of the slice is in facing relation with the coupling surface of the first optical structure; and 4) cutting the second optical structure through at least two cutting planes that are perpendicular to the coupling surface.

Turning now to FIGS. 2A-2I, there is illustrated steps of preferred methods (processes) which may be used to fabricate an optical aperture multiplier, such as the optical aperture multiplier 1, according to a first set of embodiments of the present invention.

As illustrated in FIG. 2A, a slice 110 having a plurality of external faces that includes a pair of parallel faces 112a, 112b is obtained. The slice 110 also has a plurality of mutually parallel partially reflective internal surfaces (facets) 40 that are oblique to the faces 112a, 112b. In addition, the slice 110 has another pair of faces 114a, 114b, which in certain embodiments is also a pair of parallel faces that together with the faces 112a, 112b forms a rectangular cross-section. The slice 110 may further have an additional pair of faces 116a, 116b which may or may not be parallel faces. In certain embodiments, the three pairs of faces 112a, 112b, 114a, 114b, 116a, 116b of the slice 110 are mutually orthogonal.

Parenthetically, the slice 110 is itself an optical structure, and the term "slice" is used herein as a naming convention as a way of referencing preferred methods in which the optical structure 110 can be produced. In general, the slice 110 can be obtained in various ways, typically whereby the slice is "sliced-out" from an optical structure formed of stacked plates. In one example method, as illustrated in FIG. 3A, a plurality of coated transparent plates 102 having parallel upper and lower surfaces 103a, 103b are obtained. The coatings of the coated transparent plates are selectively reflective coatings that provide the partial reflectivity of the facets 40 (i.e., such that the facets 40 are partially reflective). The plates 102 are aligned and arranged in a staggered stack, and bonded together to form a bonded stack 101, as illustrated in FIG. 3B. The bonding is such that for each plate 102, the lower surface 103b of the plate is joined with the upper surface 103a of the adjacent plate. Throughout this document, the term "bonded" or "bonding" should be understood to mean attached or attaching with an optical cement or glue, or any other suitable adhesive.

The bonded stack 101 is then cut along at least two parallel cutting planes (indicated by dashed lines 104 in FIG. 3B) that are oblique to the surfaces 103a, 103b to produce one or more slices 110. The cutting planes 104 are preferably spaced at predetermined and uniform intervals. As a result of the cutting along the cutting planes 104, each slice 110 has a pair of parallel faces 112a, 112b and a plurality of mutually parallel partially reflective internal surfaces (facets) 40 oblique to the faces 112a, 112b. It is noted that the cutting planes 104 define the oblique angle of the facets 40 in the final rectangular waveguide 10. In the illustrated embodiment, the planes 104 are perpendicular to the side surfaces of the plates 102 (which in the figure is in a plane parallel to xy plane). However, in certain embodiments, the cutting planes 104 can have an inclination angle relative to the side surfaces (xy plane), such that the facets 40 are also oblique to the parallel faces 114a, 114b. The stack 101 may be further cut along one or more pairs of cutting planes (preferably but not necessarily pairs of parallel cutting planes), that are preferably but not necessarily orthogonal to the planes 104, to set one or more of the other pairs of faces 114a, 114b, 116a, 116b of the slice 110.

Another exemplary method for obtaining the slice 110 is illustrated in FIG. 4. Here, the plates 102 are aligned and

bonded to form a non-staggered bonded stack 109 (i.e., a rectangular or approximately rectangular block), which is then cut along parallel cutting planes 104' (that are oblique to the surfaces 103a, 103b) to extract one or more slices 110.

In the illustrated embodiment, the planes 104' are perpendicular to the side surfaces of the plates 102 (which in the figure is in a plane parallel to xy plane). However, in certain embodiments, the cutting planes 104' can have an inclination angle relative to the side surfaces (xy plane), such that the facets 40 are also oblique to the parallel faces 114a, 114b. Also, similar to as with the stack 101, the stack 109 may be further cut along one or more pairs of cutting planes (preferably but not necessarily pairs of parallel cutting planes), that are preferably but not necessarily orthogonal to the planes 104', to set one or more of the other pairs of faces 114a, 114b, 116a, 116b of the slice 110.

Returning now to FIGS. 2A-2I, in certain embodiments a plate 120a can be aligned with, and applied to, the face 112a of the slice 110, as illustrated in FIGS. 2B and 2C. Alternatively, or in addition, a plate 120b can be aligned with, and applied to, the face 112b of the slice 110, also as illustrated in FIGS. 2B and 2C. The application of the plates 120a, 120b to the faces 112a, 112b constitutes an optical coupling between the plates 120a, 120b and the slice 110 at the faces 112a, 112b. In certain embodiments, the optical coupling is effectuated by bonding, whereby the plate 120a is bonded to the slice 110 such that the plate is joined with the face 112a, and/or the plate 120b is bonded to the slice 110 such that the plate 120b is joined with the face 112b.

The cover plates 120a, 120b can provide both mechanical protection to the slice 110, for example by protecting against chips that may form on the slice 110 during polishing of either or both of the faces 112a, 112b. In addition to providing mechanical protection, the cover plates 120a, 120b can serve optical functions by having various materials or coatings applied thereto. In one example, the plate 120a (and/or the plate 120b) includes a reflective coating, which prevents light from the external (real-world) scene from entering the waveguide 10, while also preserving conditions of internal reflection at the face 12a (and/or the face 12b) of the waveguide 10. In another example, the optical cement used to bond together the plate 120a (and/or the plate 120b) and the slice 110 has a low refractive index (lower than the refractive index of the material from which the slice 110 is constructed, i.e., lower than the refractive index of the plates 102) in order to maintain conditions of total internal reflection at the face 12a (and/or the face 12b) of the waveguide 10 in spite of accumulation of dirt, debris, or other particulates at the interface between the plate 120a, 120b and the slice 110. Optical cement having, for example, a refractive index of approximately 1.35 can be particularly suitable for bonding the plates 120a, 120b to the slice 110.

In certain embodiments, one of the plates 120a or 120b can have polarization managing properties (i.e., the plate 120b can be a polarization managing plate) to control or modify the polarization of the light that is to be transmitted into the waveguide 20 from the waveguide 10. The polarization management plate can be implemented, for example, as a waveplate (such as a halfwave plate) and/or a polarizer.

It is noted that instead of optically coupling plates 120a, 120b that have the aforementioned materials or coatings, the materials or coatings can be applied directly to the either or both of the faces 112a, 112b. For example, a reflective coating can be applied directly to either or both of the faces 112a, 112b to prevent unwanted reflections and preserve conditions of internal reflection at the face 112a and/or face 112b.



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Referring now to FIG. 2D, a plurality of coated transparent plates **202** having parallel upper and lower major surfaces **203a**, **203b** are obtained. The coatings of the coated transparent plates are selectively reflective coatings that provide the partial reflectivity of the facets **45** (i.e., such that the facets **45** are partially reflective) of the optical waveguide **20**.

The plates **202** are aligned and arranged in a stack (preferably a non-staggered stack), and bonded together to form a bonded stack **210** of parallel plates **202**, as illustrated in FIG. 2E. The bonding is such that for each plate **202**, the lower surface **203b** of the plate is joined with the upper surface **203a** of the adjacent plate. The bonded stack **210** has three pairs of faces **212a**, **212b**, **214a**, **214b**, **216a**, **216b**, each of which may or may not be a pair of parallel faces. The faces **212a**, **212b** are preferably parallel faces, and thus are preferably parallel to the surfaces **203a**, **203b** of the plates **202**. In addition, the surface **203a** of the top plate in the bonded stack **210** forms the face **212a**, and the surface **203b** of the bottom plate in the bonded stack **210** forms the face **212b**.

In certain embodiments, the pairs of faces **212a**, **212b** and **214a**, **214b** are both pairs of parallel faces and together form a rectangular cross-section. In certain embodiments, each of the pairs of faces of the bonded stack **210** is a pair of parallel faces, and the three pairs of faces **212a**, **212b**, **214a**, **214b**, **216a**, **216b** are mutually orthogonal. It is noted that in general, if any pair of faces of the bonded stack **210** is not initially a pair of parallel faces, either or both of the faces of that pair can be polished to achieve parallelism between the faces of the pair.

It is noted that the exemplary stack **210** in the non-limiting embodiment illustrated in FIG. 2E is a non-staggered stack, whereby the various side surfaces of the plates **202** (i.e., the surfaces of the plates **202** other than the upper and lower surfaces **203a**, **203b**) are aligned and coplanar to form generally flat and smooth faces **214a**, **214b**, **216a**, **216b**. For example, the frontside surfaces of the plates **202** that are in planes that are parallel to the yz plane are aligned to form the face **214a**, and the backside surfaces of the plates **202** (not shown) that are in planes that are parallel to the yz plane are aligned to form the face **214b**, whereby each of the faces **214a**, **214b** is a generally flat and smooth surface. Similar principles apply to the side surfaces that form the faces **216a**, **216b**. However, in certain embodiments, for example in embodiments in which the stack **210** is formed as a staggered stack, one or more of the faces **214a**, **214b**, **216a**, **216b** can include steps or variations in depth (i.e., set down or step up) of the side surfaces of the constituent plates **202** that form the stack **210**. Therefore, the term “face”, as used herein to describe and claim faces **214a**, **214b**, **216a**, **216b**, generally refers to the apparent face that is in a plane that is parallel to the surfaces of the plates **202** that form that face. For example, the face **214a** refers to the apparent face that is in a plane that is parallel to the yz plane, despite variations in depth of the frontside surfaces of the plates **202**. In embodiments in which the stack **210** is a non-staggered stack and the plates **202** are perfectly aligned (for example as illustrated in FIG. 2E), the apparent faces and the actual faces are one in the same.

Turning now to FIGS. 2F and 2G, an optical structure **220** (FIG. 2G) is produced from the bonded stack **210**. The optical structure **220** has a plurality of external surfaces (faces) that includes a planar coupling surface **222** (also referred to as a “coupling face”, “interfacing surface”, “interface surface”, or simply “face” **222**) that is oblique to the major surfaces **203a**, **203b** of the coated transparent

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plates **202** (i.e., the coupling surface **222** will be oblique to the internal facets formed from the coated transparent plates **202**). The face **24a** of the second waveguide **20** is ultimately formed from the coupling surface **222**, and thus a portion of the coupling surface **222** forms part of the interface plane between the two waveguides **10**, **20**.

The external faces of the optical structure **220** also includes a major face **234a** (formed from the face **214a** of the bonded stack **210**, as will be discussed below) that adjoins the coupling surface **222** at an angle. In certain embodiments, such as the embodiment illustrated in FIG. 2G, the adjoining angle between the coupling surface **222** and the face **234a** is  $90^\circ$  (i.e., the coupling surface **222** is perpendicular to the face **234a**). In other embodiments, the adjoining angle between the coupling surface **222** and the face **234a** is an oblique angle, preferably an acute angle. Such oblique angle embodiments are particularly suitable for producing a final optical device (optical aperture multiplier product) in which the facets **45** of the second optical waveguide **20** have a tilt angle relative to the first optical waveguide **10** (i.e., tilted relative to faces **12a**, **12b**). The selection of the particular oblique (and preferably acute) angle may be based on the optical design specification of the final optical aperture multiplier product.

In certain embodiments, the bonded stack **210** (whether non-staggered or staggered) is cut along a cutting plane **204** (FIG. 2F) to produce the optical structure **220**. In other embodiments, the optical structure **220** can be produced by grinding or polishing the bonded stack **210** to gradually remove the material in the portion **211** of the bonded stack **210** until reaching the cutting plane **204**.

The cutting plane **204** is preferably oblique to the face **212a** (and thus oblique to the upper and lower surfaces **203a**, **203b** of the plates **202** that form the stack **210**/optical structure **220**), and is at an angle relative to the face **214a**, such that the cutting plane **204** passes through portions of the faces **212a**, **216b** and such that the resulting coupling surface **222** is also oblique to the face **212a** and at an angle relative to the face **214a**. As discussed above, the angle of the cutting plane **204** relative to the face **214a** can, in certain embodiments, be  $90^\circ$  (i.e., the cutting plane **204** can be perpendicular to the face **214a**), and in other embodiments can be an oblique (preferably acute) angle.

In general, any deviation from the desired angle between the cutting plane **204** and the face **214a**, or any deviation from the desired angle between the resulting coupling surface **222** and the face **234a**, can be corrected by further polishing or slicing/cutting the optical structure **220** at the coupling surface **222** (i.e., at the location of the cutting plane **204**). To avoid wastage, the location of the cutting plane **204** in the optical structure **220** is preferably selected such that the length of the coupling surface **222** (length being measured in the “z” direction in FIG. 2G) corresponds to length of the slice **110** (also measured in the “z” direction in FIG. 2A).

The portion **211** of the bonded stack **210** that is removed (either by cutting at the cutting plane **204** or grinding or polishing to the cutting plane **204**) can, in certain embodiments, generally be a triangular prism portion that includes the following faces: i) a first portion **231a** of the face **212a** (that can be a minority portion of the face **212a**), ii) two approximately triangular portions of the faces **214a**, **214b**, and iii) a portion (which may be a rectangular portion) **237** of the face **216b**. In embodiments in which the plane **204** is perpendicular to the face **214a**, the first portion **231a** is a rectangular portion. In embodiments in which the plane **204** is oblique to the face **214a**, the first portion **231a** is a

non-parallelogram (and a “trapezoid” in American English). Note that the principles used to define the term “face” in the context of the faces **214a**, **214b**, **216a**, **216b** also apply here in the context of the faces **234a**, **234b**, **236a**, **236b**.

As a result, in certain embodiments the optical structure **220** (formed by removal of the portion **211**) can have the following faces: i) a pair of preferably parallel faces **232a**, **232b** in which the face **232a** is a second portion of the face **212a** (which is the remaining portion of the face **212a** after removal of the first portion **231a**) and in which the face **232b** is the same as the face **212b**, ii) a pair of preferably (but not necessarily) parallel trapezoidal or general quadrilateral shaped faces **234a**, **234b** that are may be perpendicular to the faces **232a**, **232b** and that are formed by removal of the triangular portions of the faces **214a**, **214b**, iii) a face **236a** that is the same as the face **216a**, and that may be perpendicular to the faces **232a**, **232b**, **234a**, **234b**, iv) a face **236b**, that may be parallel to the face **236a**, and that is the remaining portion of the face **216b** after removal of the portion **237**, and v) the interfacing face **222** that is oblique to the face **232a** (i.e., the remaining portion of the face **212a** after removal of the portion **211**) and is perpendicular (as in FIG. 2G) or oblique (preferably acute) to the face **234a** (i.e., the remaining portion of the face **214a** after removal of the portion **211**).

In embodiments in which the plane **204** is perpendicular to the face **214a**, the second portion **232a** is a rectangular portion. In embodiments in which the plane **204** is oblique to the face **214a**, the second portion **232a** is a non-parallelogram (and a “trapezoid” in American English).

Note that the plane **204** provides (defines) the boundary between the portion **231a** and the face **232a**, and also provides the boundary between the portion **237** and the face **236b**.

Again, any deviation from the desired angle between the coupling surface **222** and the face **234a** can be corrected by polishing the optical structure **220** at the location of the cutting plane **204**. In fact, since the coupling surface **222** ultimately forms part of the interface plane between the two waveguides **10**, **20**, it is preferable to polish the coupling surface **222** even in instances where there are no such angular deviations (or situations in which any such angular deviations are so minor that they do not require correction) in order to ensure that the coupling surface **222** is of high optical quality. In embodiments in which the optical structure **220** is produced by polishing the bonded stack **210** to gradually remove the material in the portion **211** of the bonded stack **210**, no further polishing step may be necessary.

Turning now to FIG. 2H, the slice **110** is optically coupled with the optical structure **220** to form an optical structure **240** (which is an intermediate work product of an optical aperture multiplier fabrication process), whereby the faces **112a**, **112b** are parallel to the coupling surface **222** and whereby one of the faces **112a** or **112b** is brought into facing relation with the coupling surface **222**. As an intermediate work product, the optical structure **240** includes the slice **110** and the optical structure **220** as respective first (or second) and second (or first) portions. In embodiments in which the slice **110** does not include any cover plate at the coupling face of the slice **110** (i.e., face **112a** or **112b**), the optical coupling is such that one of the faces **112a** or **112b** is attached to the coupling surface **222**.

In the illustrated embodiment, the face **112b** is shown as being in facing relation with the coupling surface **222**, but the face **112a** can alternatively be brought into facing relation with the coupling surface **222**. The selection of

which of the faces **112a**, **112b** is to be brought into facing relation with the coupling surface **222** can be based on the optical design specification of the final optical aperture multiplier product, including, for example, the deployment location of the optical image generator relative to the waveguide **10**. The optical coupling can be effectuated by adhesive bonding such that the face **112b** (or **112a**) and the coupling surface **222** are joined together. Alternatively, the optical coupling can be a mechanical coupling with an air gap of a designed thickness between the face **112b** (or **112a**) and the coupling surface **222**. In embodiments in which the coupling face (**112b** or **112a**) of the slice **110** has a cover plate, the optical coupling between the slice **110** and the optical structure **220** is such that the cover plate **120b** (or **120a**) is optically attached to the coupling surface **222**, which can be effectuated by bonding the cover plate **120b** (or **120a**) with the coupling surface **222** such that the cover plate **120b** (or **120a**) and the coupling surface **222** are joined together, or via mechanical coupling with an air gap between the cover plate **120b** (or **120a**) and the coupling surface **222**.

The optical structure **240** is then cut along at least two parallel cutting planes (indicated by dashed lines **244** in FIG. 2H) that are perpendicular to the coupling surface **222** and that pass through the slice **110** and the optical structure **220** to produce one or more optical aperture multipliers. A single such optical aperture multiplier is shown in FIG. 2I. It is noted that the waveguide **10** has a cover plate **13a** at the face **12a**, which is produced as a result of cutting the cover plate **120a** at the cutting planes **244**.

Although only a single optical aperture multiplier is shown as being sliced-out from the optical structure **240** in FIGS. 2H and 2I, a plurality of optical aperture multipliers can be sliced-out of the optical structure **240** by increasing the size and/or number of plates **202** used to form the bonded stack **210**.

Note that in order to maintain consistent thickness (measured arbitrarily herein along the “z-axis”) between the multiple optical aperture multipliers that are sliced out from the optical structure **240**, it is preferable that the cutting planes **244** be spaced apart at predetermined and uniform intervals.

The perpendicularity between the cutting planes **244** and the coupling surface **222** simultaneously achieves: i) parallelism between the faces **14a**, **14b** of the first optical waveguide **10**, ii) perpendicularity between first and second pairs of parallel faces **12a**, **12b**, **14a**, **14b** (thereby achieving formation of the rectangular cross-section by the faces **12a**, **12b**, **14a**, **14b**), and iii) parallelism between the faces **22a**, **22b** of the second optical waveguide **20**.

For increased (optimal) performance, it is also preferable that the cutting planes **244** are perpendicular to the face **234a** (and hence perpendicular to the face **214a**). In certain embodiments, the cutting planes **244** can be parallel to the faces **114a**, **114b**, while in other embodiments the cutting planes **244** can be oblique to the faces **114a**, **114b**.

In certain embodiments, the planes of the internal facets **40** of the slice **110** are perpendicular to the cutting planes **244**. It is noted that in embodiments in which perpendicularity between the facets **40** and the cutting planes **244** is desired, the slice **110** and the optical structure **220** should be aligned with high-degree accuracy to ensure minimal deviation from perpendicularity (for example within 20 arcseconds).

In other embodiments, the planes of the internal facets **40** of the slice **110** are oblique to the cutting planes **244**. In such embodiments, it is preferable that the angle between the

facets **40** and the cutting planes **244** is far from perpendicular, for example at least  $10^\circ$  and more preferably at least  $20^\circ$  from perpendicular.

In order to achieve the desired angle between the facets **40** and the cutting planes **244**, the slice **110** is aligned with the optical structure **220** prior to slicing out the optical aperture multiplier(s). Preferably, the slice **110** is aligned with the optical structure **220** prior to the step of optically coupling the slice **110** with the optical structure **220**.

The aligning of the slice **110** with the optical structure **220** can be performed in various ways. In one example, alignment is performed by maintaining the optical structure **220** in a fixed position and orientation and maintaining parallelism between the face **112b** or cover plate **120b** (or face **112a** or cover plate **120a**) and the coupling surface **222**, and rotating the slice **110** (with the face **112b** (or **120a**) or cover plate **120b** (or **120a**) on the coupling surface **222**) relative to the optical structure **220** until the desired angle between the facets **40** and the cutting planes **244** is achieved (for example  $90^\circ$  within 20 arcseconds if perpendicularity is desired, or for example  $80^\circ$  or less if an oblique angle between the facets **40** and the cutting planes **244** is desired). In another example, the slice **110** is maintained in a fixed position and orientation, and the optical structure **220** is rotated relative to the slice **110** while the face **112b** or cover plate **120b** (or face **112a** or cover plate **120a**) is on and parallel to the coupling surface **222** until the desired angle between the facets **40** and the cutting planes **244** is achieved. In yet another example, neither the slice **110** nor the optical structure **220** are maintained in fixed positions, and the slice **110** and the optical structure **220** are relatively rotated in opposite directions while the face **112b** or cover plate **120b** (or face **112a** or cover plate **120a**) is on and parallel to the coupling surface **222** until the desired angle between the facets **40** and the cutting planes **244** is achieved.

Parenthetically, it is noted that the oblique angle of the coupling surface **222** (and thus the oblique angle of the cutting plane **204** that forms the coupling surface **222**) relative to the upper and lower surfaces **203a**, **203b** of the plates **202** that form the stack **210**/optical structure **220** defines, in part, the oblique angle of the facets **45** of the second optical waveguide **20** of the final optical aperture multiplier product. This is primarily due to the interdependency of the orientations of the coupling surface **222** and the cutting planes **244** (i.e., the cutting planes **244** are perpendicular to the coupling surface **222**). For example, as the angle between the plane **204**/coupling surface **222** and the surfaces **203a**, **203b** becomes shallower (i.e., as the coupling surface **222** becomes closer to parallel to the face **216b**), the cutting planes **244** will produce facets **45** having a shallower inclination angle relative to the faces **22a**, **22b** of the second optical waveguide **20**. Similarly, as the angle between the plane **204**/coupling surface **222** and the surfaces **203a**, **203b** becomes steeper (i.e., as the coupling surface **222** becomes closer to parallel to the faces **212a**, **212b**), the cutting planes **244** will produce facets **45** having a steeper inclination angle relative to the faces **22a**, **22b** of the second optical waveguide **20**.

Referring again to the optical aperture multiplier illustrated in FIG. 2I, it is noted that the faces **14a**, **22a** of the optical aperture multiplier form a single continuous external face that is formed as a result of cutting the optical structure **240** along one of the cutting planes **244**. Similarly, the faces **14b**, **22b** of the optical aperture multiplier form a single continuous external face that is formed as a result of cutting the optical structure **240** along another one of the cutting planes **244**. These two continuous faces should be parallel

(since parallelism of the faces **14a**, **14b** and the faces **22a**, **22b** is critical in order to preserve conditions of internal reflection of light through both of the optical waveguides **10**, **20**). Parallelism of these two continuous faces can be preserved by ensuring that the cutting planes **244** are parallel planes. However, deviation from parallelism of the continuous faces due to deviation from parallelism of the cutting planes **244** can be corrected by polishing the continuous faces after cutting the optical structure **240** along the cutting planes **244**. In addition, preservation of parallelism of the two continuous surfaces also preserves perpendicularity between the two continuous surfaces and the faces **12a**, **12b**, which ensures perpendicularity between the two pairs of parallel faces **12a**, **12b**, **14a**, **14b** (and the formation of the rectangular cross-section) of the first optical waveguide **10**. This preservation of parallelism and perpendicularity is critical in order to preserve image uniformity as image light advances along the first optical waveguide **10** by four-fold internal reflection.

Although not illustrated in FIGS. 2A-2I, either or both of the faces **22a**, **22b** can optionally have a transparent cover plate bonded thereto or otherwise optically coupled therewith. Such transparent cover plates can be used to advantage to avoid double reflections within the LOE **20**, i.e., situations in which light is reflected twice from the same facet **45**. Specifically, the cover plates help to ensure that, after being reflected once by a facet **45**, the transmitted portion of the light will propagate over or under that facet, advancing directly to the next facet, thereby resulting in enhanced image uniformity. Examples of optical aperture multipliers having transparent cover plates attached to external faces of the LOE **20** are described in commonly owned International Patent Application No. PCT/IL2022/050216, entitled "Optical Aperture Multipliers Having a Rectangular Waveguide", filed Feb. 24, 2022.

Turning now to FIGS. 5A-5D, there are illustrated steps of preferred methods (processes) which may be used to fabricate an optical aperture multiplier according to a second set of embodiments of the present invention. In principle, the second set of embodiments are similar to the first set of embodiments in that the second set of embodiments also employ a step of optically coupling the slice **110** to an optical structure **320** to form a new optical structure from which one or more optical aperture multipliers can be extracted via slicing along two or more cutting planes. However, as mentioned above and as will become further apparent from the discussion below, the primary differences between the two sets of embodiments are with respect to the optical structures **220**, **320** with which the slice **110** is optically coupled.

Referring now particularly to FIGS. 5A and 5B, the optical structure **320** is formed as a bonded stack **321** of LOEs **20**, i.e., a stack of LOEs **20** which are bonded together. The resulting optical structure **320** (i.e., the bonded stack **321**) has a plurality of external surfaces including a pair of parallel surfaces **302a**, **302b**, and a plurality of mutually parallel partially reflective internal surfaces (facets) **45** oblique to the surfaces **302a**, **302b**.

Each of the LOEs of the bonded stack **321** is as described above with reference to FIGS. 1A and 1B, i.e., each of the LOEs has a plurality of external faces including a pair of parallel faces **22a**, **22b** (as well as additional faces **24a**, **24b**, **26a**, **26b**) and a plurality of internal facets **45** oblique to the external faces **22a**, **22b**. The internal facets **45** of each LOE **20** constitute a subset of the facets of the optical structure **320**. Although the bonded stack **321** is illustrated in FIGS. 5A and 5B as being formed from only five individual LOEs

20, a larger number of LOEs can typically be used to form the stack, including, for example, ten or more LOEs, and in certain cases twenty or more LOEs.

Methods for fabricating such individual LOEs 20 have been described extensively in various publications by Lumus Ltd. (Israel), including, for example, U.S. Pat. Nos. 7,634,214, 8,873,150, PCT publication WO 2016/103263, and PCT publication WO 2020/212835.

The external surfaces of the optical structure 320/bonded stack 321 also includes a planar coupling surface 322 (similar to coupling surface 222 of the first set of embodiments) to which the slice 110 is to be optically coupled. As will be discussed, the coupling surface 322 can be formed from the faces 24a of the constituent LOEs that form the bonded stack 321. The external surfaces of the optical structure 320/bonded stack 321 may also include a back surface 306a (formed, for example, by aligning the faces 26a of the LOEs so as to be coplanar), a front surface 306b (formed, for example, by aligning the faces 26b of the LOEs so as to be coplanar) opposite the back surface 306a, and a top (or upper) surface 308 (formed, for example, by aligning the faces 24b of the LOEs so as to be coplanar) opposite the coupling surface 322. In certain embodiments, the optical structure 320/bonded stack 321 is a rectangular cuboid, whereby the surfaces 306a and 306b, and the surfaces 308 and 322 are each a pair of parallel surfaces, and whereby the three pairs of parallel surfaces 302a, 302b, 306a, 306b, 308, 322 are mutually perpendicular.

In certain embodiments, such as the embodiments illustrated in FIGS. 5A-5D, the bonded stack 321 of LOEs 20 may also include a plurality of transparent spacer plates 324, and the LOEs and the spacer plates 324 alternate along a length of the bonded stack 321 that is perpendicular to the faces 22a, 22b of the constituent LOEs 20. Portions of these transparent spacer plates 324 form transparent cover plates bonded to the faces 22a, 22b of the final optical aperture multiplier product. In such embodiments, a given spacer plate 324 is bonded with two adjacent LOEs such that the face 22a of a first adjacent LOE is joined to one side of the spacer plate 324 and the face 22b of a second adjacent LOE is joined to the opposing side of the spacer plate 324.

In embodiments in which no transparent spacer plates 324 are employed, adjacent LOEs are bonded together such that the face 22a of each LOE is joined to the face 22b of the adjacent LOE.

In order to form the bonded stack 321, the LOEs 20 are preferably aligned such that all of the faces 22a, 22b of the LOEs are mutually parallel, and such that all of the internal facets 45 of the LOEs are mutually parallel (as shown in FIGS. 5A and 5B). In addition, the faces 24a of the LOEs 20 may be aligned so as to be coplanar, thereby forming the coupling surface 322. In embodiments having spacer plates 324, alignment of the faces 24a may also include alignment of the minor external surfaces of the spacer plates 324. It is noted that if the faces 24a are not aligned so as to be coplanar, the bonded stack 321 can be cut and polished along a plane that is perpendicular to the faces 22a, 22b of the LOEs 20 to remove extraneous portions of one or more of the LOEs in order to produce the coupling surface 322.

The pair of parallel surfaces 302a, 302b of the optical structure 320 are parallel to the faces 22a, 22b of the individual LOEs 20. Furthermore, in embodiments in which spacer plates 324 are provided, the surface 302a is formed from the spacer plate 324 at one end of the stack 321 (the right end in FIG. 5B), and the surface 302b is formed from the spacer plate 324 at the opposite end of the stack 321 (the left end in FIG. 5B). Parenthetically, the two spacer plates

324 at the ends of the stack 321 may have an increased thickness relative to the spacer plates 324 that are at the interior portions of the stack 321. In addition, the spacer plates 324 at the interior portions of the stack preferably have a common (i.e., same) thickness.

In embodiments in which no spacer plates 324 are provided, the surface 302a is formed from the face 22a of the LOE at one end of the stack 321 (the right end in FIG. 5B), and the surface 302b is formed from the face 22b of the LOE at the opposite end of the stack 321 (the left end in FIG. 5B).

As illustrated in FIG. 5C, the slice 110 is optically coupled with the optical structure 320/bonded stack 321 to form an optical structure 340 (which is an intermediate work product of an optical aperture multiplier fabrication process), whereby the faces 112a, 112b are parallel to the coupling surface 322 and whereby one of the faces 112a or 112b is brought into facing relation with the coupling surface 322. As an intermediate work product, the optical structure 340 includes the slice 110 and the optical structure 320 (bonded stack 321) as respective first (or second) and second (or first) portions. It is noted that by way of illustrative example only, FIG. 5C show an optical structure 320 that is formed as a bonded stack of 18 LOEs (as opposed to the five LOE stack illustrated in FIGS. 5A and 5B).

Note that although FIG. 5C shows the slice 110 as having a single cover plate (cover plate 120a attached to the face 112a), it should be understood that the face 112b (which is the coupling face of the slice 110) can also have a cover plate 120b bonded therewith.

In embodiments in which the slice 110 does not include any cover plate at the coupling face of the slice 110 (i.e., face 112a or 112b), the optical coupling between the slice 110 and the optical structure 320 is such that one of the faces 112a or 112b is attached to the coupling surface 322. In the illustrated embodiment, the face 112a is shown as being in facing relation with the coupling surface 322, but the face 112b can alternatively be brought into facing relation with the coupling surface 322. The optical coupling can be effectuated by adhesive bonding such that the face 112a (or 112b) and the coupling surface 322 are joined together. Alternatively, the optical coupling can be a mechanical coupling with an air gap of a designed thickness between the face 112a (or 112b) and the coupling surface 322.

In embodiments in which the coupling face (112b or 112a) of the slice 110 has a cover plate, the optical coupling between the slice 110 and the optical structure 320 is such that the cover plate 120a (or 120b) is optically attached to the coupling surface 322, which can be effectuated by bonding the cover plate 120a (or 120b) with the coupling surface 322 such that the cover plate 120a (or 120b) and the coupling surface 322 are joined together, or via mechanical coupling with an air gap between the cover plate 120a (or 120b) and the coupling surface 322.

The optical structure 340 is then cut along at least two preferably parallel cutting planes (indicated by dashed lines 344 in FIG. 5C) that are parallel to the faces 22a, 22b of the LOEs 20 and are perpendicular to the coupling surface 322, and that pass through the slice 110 and the optical structure 320, to produce one or more optical aperture multipliers. A single such optical aperture multiplier 1' is shown in FIG. 5D. Similar to the optical aperture multiplier 1 of FIG. 2I, the waveguide 10 has cover plate 13a at the face 12a, which is produced as a result of cutting the cover plate 120a at the cutting planes 344. Note that in contrast to the optical aperture multiplier 1 of FIG. 2I, the optical aperture multi-

plier 1' also has cover plates **39a**, **39a** (formed by cutting through consecutive spacer plates **324**) attached to faces **22a**, **22b**.

Although only a single optical aperture multiplier is shown as being sliced-out from the optical structure **340** in FIGS. **5C** and **5D**, a plurality of optical aperture multipliers can be sliced-out of the optical structure **340**.

Any deviation from parallelism of the cutting planes **344** relative to the faces **22a**, **22b** can be corrected by polishing the sliced-out optical aperture multiplier at the sight/location of the cuts along the cutting planes **344**.

In embodiments in which transparent spacer plates **324** are employed, two consecutive cutting planes **344** are located in consecutive spacer plates having one of the LOEs **20** of the bonded stack **321** sandwiched therebetween. Preferably each cutting plane is located at the center of the corresponding spacer plate **324** so as to effectively divide the spacer plate **324** into two approximately equal portions. It is noted that in situations in which it is desirable to have transparent cover plates bonded to the faces **22a**, **22b** of the waveguide **20**, fabrication of the optical aperture multiplier according to the second set of embodiments may be preferable to fabrication according to the first set of embodiments. This is due to the fact that fabrication of the optical aperture multiplier according to the second set of embodiments results in the cover plates (designated **39a** and **39b** in FIG. **5D**) being flush with the side surfaces **14a**, **14b** of the waveguide thereby providing a sleek configuration in which the cover plates do not protrude beyond the surfaces **14a**, **14b** (which can occur when applying cover plates to waveguide **20** fabricated according to the first set of embodiments).

In embodiments in which no transparent spacer plates **324** are employed, it is preferable that consecutive cutting planes **344** are located between the faces **22a**, **22b** of consecutive LOEs **20** of the bonded stack **321**, and more preferably at the bonding regions formed between the faces **22a**, **22b** of consecutive LOEs **20**, such that each sliced-out optical aperture multiplier has only one of the LOEs **20** of the bonded stack **321**. For example, a first of the cutting planes preferably passes between the bonding region between the face **22b** of a first one of the LOEs **20** and the face **22a** of a second one of the LOEs **20** that is adjacent to, and bonded with, the first one of the LOEs **20**. A second of the cutting planes that is adjacent to the first of the cutting planes passes between the bonding region between the face **22b** of the second one of the LOEs **20** and the face **22a** of a third one of the LOEs **20** that is adjacent to, and bonded with, the second one of the LOEs **20**. It is noted herein that the bonding regions (formed between the faces **22a**, **22b** of consecutive LOEs) can provide guides for placement of the cutting planes **344**.

Prior to formation of the optical structure **340** (with or without spacer plates **324**), the slice **110** and the optical structure **320** are preferably properly aligned in order to achieve increased optical performance in a vein similar to as described above with reference to FIG. **2H**. For example, the slice **110** and the optical structure **320** are preferably aligned such that the surface **302a** and one of the faces **114a** or **114b** are parallel (and preferably coplanar), and such that the surface **302b** and the other of the faces **114b** or **114a** are parallel (and preferably coplanar). It may also be preferable to align the slice **110** and the optical structure **320** such that the surface **306a** and one of the faces **116a** or **116b** are parallel (and preferably coplanar), and such that the surface

**306b** and the other of the faces **116b** or **116a** are parallel (and preferably coplanar). Such preferred alignment is illustrated in FIG. **5C**.

Alignment may be achieved by rotating the slice **110** relative to the optical structure **320**, similar to as describe above when discussing alignment of the slice **110** and the optical structure **220**. It is also noted that the alignment and optical coupling between the slice **110** and the optical structure **320** necessarily results in the facets **40** being non-parallel to the facets **45**.

Note that in the embodiments described herein, the slice **110** has an initial direction of elongation (illustrated arbitrarily herein as corresponding to the “z-axis”) which is perpendicular to the direction of elongation of the waveguide **10**, and which is also generally perpendicular to the cutting planes **244**, **344**. This direction of elongation of the slice **110** enables multiple optical aperture multipliers to be extracted from the optical structure (**240** or **340**) whereby the waveguide portion of each extracted optical aperture multiplier is extracted from the slice **110** portion of the optical structure (**240** or **340**).

It is noted that one or more additional optical components can be optically coupled or bonded with the optical aperture multiplier product, produced using the methods described herein, at one or more external faces of the waveguides. Examples of such optical components include, for example, optical coupling-in configurations, polarizers, depolarizers, and lenses. Optical coupling-in configurations, in the form of external coupling prisms or external coupling reflector arrangements, are used to introduce/inject collimated image light from an optical image generator into the first optical waveguide **10** such that the injected image advances through the first optical waveguide **10** by four-fold internal reflection.

By way of one set of examples, any of the coupling prisms described in US Patent No. 10,133,070, for example with reference to FIGS. **8A-14C** of that document, can be bonded or otherwise optically coupled with the first optical waveguide **10** in order to provide light injection to the first optical waveguide **10**. In certain cases, attachment of such a coupling prism may require application of additional coating to parts of the external waveguide faces **12a**, **12b**, **14a**, **14b** and/or cutting or otherwise removing a portion of the first optical waveguide **10**.

In another set of examples, a coupling prism (which in certain configurations may also include a coupling reflector on one of the faces of the coupling prism) can be deployed in association with a portion of the front or back face **14a**, **14b** of the first optical waveguide **10**, for example as described in commonly owned International Patent Application No. PCT/IL2022/050216, entitled “Optical Aperture Multipliers Having a Rectangular Waveguide”, filed Feb. 24, 2022. Such deployment may require dividing the face **12a** or **12b** into a first region (corresponding to a majority portion of the face **12a** or **12b**) and a second region (corresponding to the remaining minority of the face **12a** or **12b**) that have different optical characteristics. The subdivision can be effectuated by a coating or material deployed in association with a majority portion or a minority portion of the face **12a** or **12b**, which can be accomplished by applying such coating or material to the requisite portions of the face **112a** or **112b** of the slice **110**.

The optical image generator that provides the collimated image to the optical coupling-in configuration is typically a micro projector optical device, that includes at least one light source, typically deployed to illuminate a spatial light modulator, such as a liquid crystal on silicon (LCoS) chip. The

spatial light modulator modulates the projected intensity of each pixel of the image, thereby generating an image. Alternatively, the optical image generator may include a scanning arrangement, typically implemented using a fast-scanning mirror, which scans illumination from a laser light source across an image plane of the image generator while the intensity of the beam is varied synchronously with the scanning motion on a pixel-by-pixel basis, thereby projecting a desired intensity for each pixel. In both cases, collimating optics are provided to generate an output projected image which is collimated to infinity. Some or all of the above components of the image generator are typically arranged on surfaces of one or more polarizing beamsplitter cube or other prism arrangement, as is well known in the art.

As mentioned above, it may be desirable to provide one or more additional optical components, in particular optical coupling-in components, to be optically coupled with the optical aperture multiplier. To this end, it may be particularly advantageous to provide an additional optical structure—from which optical coupling-in components can be extracted—that can be optically coupled with the optical structures described above in order to enable mass-production of optical aperture multipliers each having a pair of waveguides and an optical coupling-in configuration attached thereto or otherwise optically coupled therewith. Bearing this in mind, FIGS. 6A-6E illustrate steps of methods (processes) which may be used to fabricate an optical aperture multiplier having waveguides 10, 20 and an optical coupling-in configuration bonded to (or otherwise optically coupled with) the waveguide 10, according to embodiments of the present invention. FIG. 6A illustrates an additional optical structure 420 from which multiple optical coupling-in configurations can be extracted, and FIGS. 6B-6E illustrate an optical structure 500 formed by the optically coupling of the optical structure 420 with the optical structure 340 and the extraction of an optical aperture multiplier from the optical structure 500. It is noted that although the examples illustrated in FIGS. 6B-6D are provided within the context of the fabrication process according to the second set of embodiments, similar techniques can also be applied to the fabrication process according to the first set of embodiments.

Turning now to FIGS. 6A-6E in detail, the optical structure 420 is formed from a light-transmitting material and has a plurality of external faces including a pair of parallel faces 402a, 402b, and a plurality of mutually parallel internal surfaces 50 oblique to the faces 402a, 402b. The external faces of the optical structure 420 can also include faces 404a, 404b (which in certain embodiments can be a pair of parallel faces that are perpendicular to faces 402a, 402b) as well as faces 406a, 406b (which in certain embodiments can be a pair of parallel faces, and can also be perpendicular to faces 402a, 402b, 404a, 404b).

In certain embodiments, the internal surfaces 50 are reflective surfaces, whereas in other embodiments the internal surfaces 50 are partially reflective surfaces (such as beam splitting surfaces). The optical structure 420 can be obtained in various ways, including producing the optical structure 420 by stacking and bonding together transparent plates (which can be coated with reflective or partially reflective coatings) and then slicing the bonded plates, in a manner similar to that used to produce the slice 110, as described above.

As illustrated in FIGS. 6B-6D, the optical structure 420 is optically coupled with the slice 110 portion of the optical structure 340 such that a coupling face of the optical structure 420 (which can be one of the faces 402a, 402b) is

brought into facing relation with one of the external faces of the slice 110. The optically coupling between the optical structures 340, 420 produces a new optical structure 500 that is an intermediate work product having three portions: 1) the bonded stack of LOEs portion (i.e., optical structure 320), 2) the slice 110 portion, and 3) the optical structure 420 portion.

In the illustrated embodiments, the coupling face of the optical structure 420 is the face 402a, which is deployed in facing relation to the face 116b of the slice 110. In certain embodiments, the optical structure 420 is bonded with the slice 110 such that the coupling face (e.g., face 402a) is joined to the face 116b (or face 116a). Note that the selection of which of the external faces of the slice 110 is to be brought into facing relation with the coupling face of the optical structure 420 can be based on the optical design specification of the final optical aperture multiplier product, including, for example, the deployment location of the optical image generator relative to the optical coupling-in configuration and the waveguide 10.

Prior to optically coupling the optical structure 420 with the slice 110, the optical structure 420 and the slice 110 are preferably aligned. In the illustrated embodiment, the alignment is preferably such that each internal surface 50 corresponds to, and is preferably located between the faces 22a, 22b of, a corresponding one of the LOEs of the bonded stack 321. In certain embodiments, the alignment is such that each internal surface 50 extends between the faces 22a, 22b of the corresponding LOE. The alignment is further such that the internal surfaces 50 are non-parallel to the facets 40 and 45.

In certain embodiments, the alignment of the optical structure 420 with the slice 110 is also such that the faces 114a and 406a are parallel (and preferably coplanar), and such that the faces 114b and 406b are parallel (and preferably coplanar).

FIG. 6D shows the optical structure 500 with example cutting planes 344 (same as illustrated in FIG. 5C). The optical structure 500 is cut along the two or more cutting planes 344 to produce (extract/slice-out) one or more optical aperture multipliers. A single such sliced-out optical aperture multiplier 1", having a pair of waveguides (10, 20) and a coupling-in configuration 42 attached thereto, is illustrated in FIG. 6E. The optical coupling-in configuration 42 is produced from the optical structure 420 and includes a single internal surface 50.

Note that although the slice 110 is illustrated without cover plates 120a, 120b in the embodiments of FIGS. 6A-6E, it should be understood that one or both of the cover plates 120a, 120b can be applied to the respective faces 112a, 112b.

As mentioned above, similar techniques for producing optical aperture multipliers with attached optical coupling-in configurations can be used with the fabrication process according to the first set of embodiments. For example, the optical structure 420 can be optically coupled with the optical structure 240 of FIG. 2H, for example at the face 116b, in order to produce an optical aperture multiplier having a pair of waveguides 10, 20 and an optical coupling-in configuration 42 attached thereto.

It is noted that the optical structure 420 illustrated in the drawings is just one non-limiting example of an optical structure from which optical coupling-in configurations can be extracted. In general, any optical structure having a coupling surface (e.g., face 402a) and a plurality of optical coupling-in surfaces (e.g., internal surfaces 50) or elements or surface sections geometrically associated with the coupling surface can be optically coupled with the optical structure 340 or 240. An elongated prism is another non-

limiting example of an optical structure from which optical coupling-in configurations can be extracted. Such an elongated prism may have a plurality of external surfaces that includes a coupling surface (for optically coupling with the slice **110**) and an optical coupling-in surface that can be subdivided into a plurality of non-overlapping sections. Each section can correspond, for example, to a different respective LOE **20** of the optical structure **320**, such that when sliced along cutting planes **344** each section becomes the optical coupling-in surface for the optical aperture multiplier.

The alignment of the various optical structures described herein can be performed using any suitable optical alignment apparatus/device(s)/tool(s) that perform suitable optical alignment techniques/methods. Such suitable optical alignment apparatus/device(s)/tool(s) can include, for example, one or more computerized control device, one or more computerized processing device, one or more optical subsystem having, for example, one or more light source, one or more light detector/sensor (including optical sensors), one or more optical component (e.g., one or more lens, one or more folding optic, one or more prism, etc.), autocollimators, and the like. Details of non-limiting examples of suitable optical alignment apparatus/device(s)/tool(s)/method(s) that can be used for aligning the various optical structures described herein can be found in various publications by Lumus Ltd. (Israel), including, for example, International Patent Application No. PCT/IL2021/051377 and International Patent Application No. PCT/IL2021/051378.

The present disclosure has described various cutting steps in which optical structures or materials are cut along cutting planes in order to produce various other optical structures or optical products. It is noted that in certain embodiments, some or all of the surfaces of these optical structures and materials, including and in particular those surfaces that result from these cutting steps, can be polished to, for example, increase optical quality. In certain embodiments, polishing can be performed as part of, or subsequent to, these cutting steps, and prior to subsequent optical coupling (e.g., bonding) steps. In the above-described fabrication methods, the cutting or slicing of the various optical structures described herein can be performed by any suitable cutting apparatus/device/tool, as should be understood by those of ordinary skill in the art. The polishing of the faces and surfaces of the various optical structures described herein can be performed by any suitable polishing apparatus/device/tool, as should be understood by those of ordinary skill in the art.

The descriptions of the various embodiments of the present disclosure have been presented for purposes of illustration, but are not intended to be exhaustive or limited to the embodiments disclosed. Many modifications and variations will be apparent to those of ordinary skill in the art without departing from the scope and spirit of the described embodiments. The terminology used herein was chosen to best explain the principles of the embodiments, the practical application or technical improvement over technologies found in the marketplace, or to enable others of ordinary skill in the art to understand the embodiments disclosed herein.

As used herein, the singular form, “a”, “an” and “the” include plural references unless the context clearly dictates otherwise.

The word “exemplary” is used herein to mean “serving as an example, instance or illustration”. Any embodiment described as “exemplary” is not necessarily to be construed

as preferred or advantageous over other embodiments and/or to exclude the incorporation of features from other embodiments.

It is appreciated that certain features of the invention, which are, for clarity, described in the context of separate embodiments, may also be provided in combination in a single embodiment. Conversely, various features of the invention, which are, for brevity, described in the context of a single embodiment, may also be provided separately or in any suitable subcombination or as suitable in any other described embodiment of the invention. Certain features described in the context of various embodiments are not to be considered essential features of those embodiments, unless the embodiment is inoperative without those elements.

Although the invention has been described in conjunction with specific embodiments thereof, it is evident that many alternatives, modifications and variations will be apparent to those skilled in the art. Accordingly, it is intended to embrace all such alternatives, modifications and variations that fall within the spirit and broad scope of the appended claims.

What is claimed is:

1. A method of fabricating an optical aperture multiplier comprising:

obtaining a slice having a plurality of external faces including a pair of parallel faces and a first plurality of mutually parallel partially reflective internal surfaces (**40**) oblique to the pair of parallel faces;

obtaining a first optical structure having a plurality of external surfaces including a planar coupling surface, and a second plurality of mutually parallel partially reflective internal surfaces oblique to the coupling surface;

optically coupling the slice with the first optical structure such that one of the faces of the pair of parallel faces is brought into facing relation with the coupling surface, thereby forming a second optical structure; and slicing out at least one optical aperture multiplier from the second optical structure by cutting the second optical structure through at least two cutting planes that are perpendicular to the coupling surface.

2. The method of claim 1, wherein the first optical structure is formed as a bonded stack of light-guide optical elements (LOEs), each LOE of the bonded stack having a pair of major parallel surfaces and a subset of the second plurality of mutually parallel partially reflective internal surfaces oblique to the pair of major parallel surfaces.

3. The method of claim 2, wherein the at least two cutting planes are substantially parallel to the major parallel surfaces of consecutive LOEs.

4. The method of claim 2, wherein the bonded stack includes a plurality of transparent spacer plates, wherein the LOEs and the transparent spacer plates alternate along a length of the bonded stack perpendicular to the major parallel surfaces of the LOEs.

5. The method of claim 4, wherein the at least two cutting planes are located in consecutive spacer plates having one of the LOEs sandwiched therebetween.

6. The method of claim 1, wherein the first optical structure is produced from a bonded stack of coated transparent plates.

7. The method of claim 6, wherein the bonded stack has a pair of faces, and wherein the first optical structure is produced from the bonded stack by cutting the bonded stack along a cutting plane that is at an angle relative to at least one of the faces of the pair of faces of the bonded stack.

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8. The method of claim 7, wherein the first optical structure is produced from the bonded stack by further polishing or slicing at the location of the cutting plane to form the coupling surface.

9. The method of claim 1, further comprising:

obtaining a third optical structure having a plurality of external faces including a coupling face, and a plurality of mutually parallel internal surfaces oblique to the coupling face; and

prior to slicing out the at least one optical aperture multiplier, optically coupling the third optical structure with the slice such that coupling face of the third optical structure is brought into facing relation with one of the external faces of the slice.

10. The method of claim 1 further comprising: optically coupling a cover plate with the slice at one or more of the faces of the pair of parallel faces.

11. The method of claim 10, wherein the cover plate includes a reflective coating.

12. The method of claim 10, wherein the optically coupling the cover plate with the slice includes bonding the cover plate with one or more of the faces of the pair of parallel faces.

13. The method of claim 12, wherein the bonding is performed using an optical cement having a refractive index that is lower than a refractive index of a material used to produce the slice.

14. The method of claim 10, wherein the cover plate is optically coupled with the slice at the one of the faces of the pair of parallel faces that is brought into facing relation with the coupling surface, and wherein the cover plate has polarization managing properties.

15. The method of claim 14, wherein the cover plate includes at least one of a waveplate or a polarizer.

16. A method of fabricating an optical aperture multiplier comprising:

obtaining a slice having a plurality of external faces including a pair of parallel faces and a plurality of mutually parallel partially reflective internal surfaces oblique to the pair of parallel faces;

producing from a bonded stack of coated transparent plates a first optical structure having a plurality of external surfaces including a coupling surface oblique to major surfaces of the coated transparent plates;

optically coupling the slice with the first optical structure such that one of the faces of the pair of parallel faces is brought into facing relation with the coupling surface, thereby forming a second optical structure; and slicing out at least one optical aperture multiplier from the second optical structure by cutting the second optical structure through at least two cutting planes that are perpendicular to the coupling surface.

17. An optical structure that is an intermediate work product of an optical aperture multiplier fabrication process, the optical structure comprising:

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a first portion comprising a plurality of external faces including a pair of parallel faces, and a first plurality of mutually parallel partially reflective internal surfaces oblique to the pair of parallel faces; and

a second portion comprising a plurality of external surfaces including a coupling surface, and a second plurality of mutually parallel partially reflective internal surfaces oblique to the coupling surface, wherein the second portion is optically coupled with the first portion such that one of the faces of the pair of parallel faces is in facing relation with the coupling surface and such that at least one optical aperture multiplier is produced when the optical structure is sliced through at least two substantially parallel cutting planes that pass through the first portion and the second portion and are perpendicular to the coupling surface.

18. The optical structure of claim 17 further comprising: a cover plate optically coupled with the first portion at one or more of the faces of the pair of parallel faces.

19. The optical structure of claim 18, wherein the cover plate includes a reflective coating.

20. The optical structure of claim 18, wherein the cover plate is optically coupled with the first portion by bonding the cover plate to one of the faces of the pair of parallel faces.

21. The optical structure of claim 20, wherein the bonding is performed using an optical cement having a refractive index that is lower than a refractive index of a material used to produce the first portion.

22. The optical structure of claim 18, wherein the cover plate is optically coupled with the first portion at the one of the faces of the pair of parallel faces that is in facing relation with the coupling surface, and wherein the cover plate has polarization managing properties.

23. The optical structure of claim 22, wherein the cover plate includes at least one of a waveplate or a polarizer.

24. An optical structure that is an intermediate work product of an optical aperture multiplier fabrication process, the optical structure comprising:

a first portion having a plurality of external faces including a pair of parallel faces and a plurality of mutually parallel partially reflective internal surfaces oblique to the first pair of parallel faces; and

a second portion, formed from a bonded stack of coated transparent plates, having a plurality of external surfaces including a coupling surface oblique to major surfaces of the coated transparent plates, the first portion optically coupled with the second portion such that one of the faces of the pair of parallel faces is in facing relation with the coupling surface and such that at least one optical aperture multiplier is produced when the optical structure is sliced through at least two substantially parallel cutting planes that pass through the first and second portions and are perpendicular to the coupling surface.

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